

ORD10647



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K6A 1K7
Canada

Tel (613) 632-5200
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D350-636-013
Job Sheet 185412

**Part No:** D350-636-013**Job Qty:** 1 ea**Part Name:** Skidtube LH, Std Wearplates, DART (Apical) Tri-Bag/Air Cruisers Float Comp.**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 10/25/18**Job Tracking No:****Due Date:** 11/9/18**Created By:** Jesse White**Type:** SOLD**Description:**

Note: DWG REV G SHEETS 1,3,6,10 IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13 As per dsi9343 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 DD verified:EC IPP Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD verf:EC IPP Rev:P 10.06.22 revise seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH DDverf:EC IPP REV:R 13.08.27 PER ECN13-594 DD VERF:JLM

Ship Via:**Bill of Materials**

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Skid tubes-1		BE
110	Skid tubes	1 pcs	11/9/18	11/9/18	0.00	4.62	Skid tubes-1		BE
120	QC	1 pcs	11/9/18	11/9/18	0.00	0.00	QC10		38 DAS
130	QC	1 pcs	11/9/18	11/9/18	0.00	0.00	QC5		9-89 38
140	HandFinish	1 pcs	11/9/18	11/9/18	0.00	0.97	HandFinish1		D.R 18/10/31
150	QC	1 pcs	11/9/18	11/9/18	0.00	0.00	QC7-2		MCG
160	Skid tubes	1 pcs	11/9/18	11/9/18	0.00	4.62	Skid tubes-1		38 DAS BE 3/4
170	QC	1 pcs	11/9/18	11/9/18	0.00	0.00	QC10		38 DAS
180	QC	1 pcs	11/9/18	11/9/18	0.00	0.00	QC5		9-89 38
190	HandFinish	1 pcs	11/9/18	11/9/18	0.00	0.97	HandFinish2		D.R 18/11/12
200	Spray Paint	1 pcs	11/9/18	11/9/18	0.00	0.37	Spray Paint		NOV 15 2018
210	QC	1 pcs	11/9/18	11/9/18	0.00	0.00	QC14		18-11-13
230	HandFinish	1 pcs	11/9/18	11/9/18	0.00	0.97	HandFinish4		11-12-19
240	QC	1 pcs	11/9/18	11/9/18	0.00	0.00	QC5		11-12-19 DAS
250	Packaging	1 pcs	11/9/18	11/9/18	0.00	0.00	Packaging1-3		NOV 20 2018 68
260	QC	1 pcs	11/9/18	11/9/18	0.00	0.00	QC4		9-89
270	Packaging	1 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-1		9-89
275	DC	1 pcs	11/9/18	11/9/18	0.00	0.00	DC		DEC 11 2018
280	QC21-FG	1 Ea	11/9/18	11/9/18	0.00	0.00	QC21		DEC 11 2018

Part Op 110 - 1- Pick D2600-3 Bent Drill pilot holes as per Dwg D2750 sheet 4 (D2750-3 details). Drill using drill Jig DT8150 & Descriptions: DT8864A for second side only DT8864B for first side (detail B) 7- Open up holes of Detail A to 0.297" (total of 2 holes per side)

160 - 1-Open up holes using hole saw on section AW-AW 0.500" (4 per side) as per dwg D2750 2-Open holes using hole saw on section BC-BC 0.3125" (4 per side) 3-Open up holes using uni-bit of Detail T and ground handling to 0.625" (total of 8 holes per side Detail AV-AV) as per dwg D2750. 4-Chamfer holes of section AW-AW, AV-AV, T and ground handling. (welding instructions on sheet 10) 5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required. 6-Bond web D2739 in place as per QSI 015, let cure for 12hrs. 7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 10) 8-Grind welds flush as per Dwg D2750 9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750 10-Deburr holes, ensure tube is free of all scratches before sending to paint.

180 - ***VERIFY C'BOARD IS GOOD***

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2

210 - Inspect for foreign object per QSI 024

230 - 1- Install inserts as per dwg D2750 2- Inspect for Foreign Object

270 - Package as per PPP D350-636-013

275 - Photocopy blue file and type labels per PPP D350-636-013 CHG 007

DAS
21
9-89

chgoos
Dec attachment

82

1907

Amel

Job BOM

Part / Item	Component Name	Quantity	Operation
D2600-3-BENT-LH	Extrusion Bent LH	1 Ea (1 ea)	90-Start up Operation
D3493-1	Washer	2 Ea (2 ea)	90-Start up Operation
D2739	350 I-Beam	1 Ea (1 ea)	160-Skiddtubes
D2744	Cap	1 Ea (1 ea)	160-Skiddtubes
D3490-1	Cross Bolt Spacer	4 Ea (4 ea)	160-Skiddtubes
D3490-5	Cross Bolt Spacer	4 Ea (4 ea)	160-Skiddtubes
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-HandFinish
AN3C5A	Bolt	34 Ea (34 ea)	230-HandFinish
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish
D2745	Bushing	8 Ea (8 ea)	230-HandFinish
D3488-041	Blade Fitting LH	1 Ea (1 ea)	230-HandFinish
D3492-5	Plug	8 Ea (8 ea)	230-HandFinish
D3535-25	Wearplate Center	1 Ea (1 ea)	230-HandFinish
D3536-25	Gasket Center	1 Ea (1 ea)	230-HandFinish
D3537-1	Wearpad	3 Ea (3 ea)	230-HandFinish
D3631-1	Washer	8 Ea (8 ea)	230-HandFinish
D3791-1	Wearpad	1 Ea (1 ea)	230-HandFinish
D3793-1	Wearplate Fwd	1 Ea (1 ea)	230-HandFinish
D3793-3	Wearplate Aft	1 Ea (1 ea)	230-HandFinish
D3794-1	Gasket Fwd	1 Ea (1 ea)	230-HandFinish
D3794-3	Gasket Aft	1 Ea (1 ea)	230-HandFinish
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish
NAS1149C0332R	Washer	38 Ea (38 ea)	230-HandFinish
NAS1149C0832R	Washer	1 Ea (1 ea)	230-HandFinish
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish
NAS1611-005	O-Ring	8 Ea (8 ea)	230-HandFinish
NAS1611-010	O-Ring	8 Ea (8 ea)	230-HandFinish
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging
D2741	Replacement Blade	1 Ea (1 ea)	250-Packaging
D2743	Crossbolt Spacer	8 Ea (8 ea) + 1	250-Packaging
D3492-1	Plug	8 Ea (8 ea)	250-Packaging
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging

006533

Container

S109648

S125817

S120672

S060499

S082748

F158391

S058139

S095214

S0619457

S006333

S096794

S128862

F158789

S102651

S097987

S115013

S097219

S058467

S098605

S089345

S089463

S108630

S099637

S058141

S090633

S089465

S076817-2

S083559

S087657

S128709

S068565

S122933

S127306

S128914

S089248

DART
AEROSPACE

Container No: S122630

Part: D350 - 636 - 013

Job No: 185412

Serial No/Batch: S122630

Revision:
Inspector:
Exp Date:

Instructions: TC STC SH99 - 7 Issue 2, FFA/STIA SH00646SE 15/10/28, EASA STC

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Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-3-BENT-LH	1	8	0
	D3493-1	2	11	0
160-Skidtubes	D2739	1	2	0
	D2744	1	32	0
	D3490-1	4	67	0
	D3490-5	4	24	0
230-HandFinish	ALS4-1032-225	38	1,744	0
	AN3C5A	34	1,596	0
	AN3C6A	4	221	0
	AN6C44A	4	136	0
	AN8C35A	1	45	0
	D2745	8	91	0
	D3488-041	1	6	0
	D3492-5	8	115	0
	D3535-25	1	16	0
	D3536-25	1	28	0
	D3537-1	3	234	0
	D3631-1	8	515	0
	D3791-1	1	24	0
	D3793-1	1	19	0
	D3793-3	1	11	0
	D3794-1	1	18	0
	D3794-3	1	29	0
	MS21043-6	4	159	0
	MS21083C8	1	174	0
	NAS1149C0332R	38	3,061	0
	NAS1149C0832R	1	385	0
	NAS1515H3L	4	449	0
	NAS1611-005	8	219	0
	NAS1611-010	8	695	0
250-Packaging	AN8C21A	2	99	0
	D2741	1	58	0
	D2743	8	7	0
	D3492-1	8	90	0
	MS21083C8	2	174	0
	NAS1149D0863J	2	94	0

Part Specifications

Specifications could not be found.

Plex 10/25/18 4:13 PM dart.white.jesse

QTY -041	QTY -042	QTY -043	QTY -044	QTY -051	QTY -052	P/N	DESCRIPTION
X						D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X					D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X				D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X			D2750-044	350 SKIDTUBE ASSEMBLY, RH
				X		D2750-051	350 SKIDTUBE ASSEMBLY, LH
					X	D2750-052	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	1	1	D2739	WEB
8	8	8	8	8	8	D2743	CROSS BOLT SPACER
1	1	1	1	1	1	D2744	CAP
8	8	8	8	8	8	D2745	BUSHING
1						D2750-1	350 SKIDTUBE ASSEMBLY
	1					D2750-2	350 SKIDTUBE ASSEMBLY
		1				D2750-3	350 SKIDTUBE ASSEMBLY
			1			D2750-4	350 SKIDTUBE ASSEMBLY
				1		D2750-5	350 SKIDTUBE ASSEMBLY
					1	D2750-6	350 SKIDTUBE ASSEMBLY
1		1		1		D3488-3	BLADE FITTING, LH
	1		1		1	D3488-4	BLADE FITTING, RH
4	4	4	4			D3490-1	CROSS BOLT SPACER
4	4					D3490-3	CROSS BOLT SPACER
		4	4			D3490-5	CROSS BOLT SPACER
8	8	8	8			D3492-041	PLUG
8	8					D3492-043	PLUG
		8	8			D3492-045	PLUG
3	3	3	3	3	3	D3537-1	WEARPAD
8	8	8	8	8	8	D3631-1	WASHER
1	1	1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	1	1	D3793-5	WEARSHOE
38	38	38	38	38	38	ALS4-1032-225	INSERT
				1	1	AN3C34A	BOLT
34	34	34	34	34	34	AN3C5A	BOLT
4	4	4	4	4	4	AN3C8A	BOLT
4	4	4	4	4	4	AN6C44A	BOLT
1	1	1	1	1	1	AN8C35A	BOLT
				1	1	MS21043-3	NUT
4	4	4	4	4	4	MS21043-6	NUT
1	1	1	1	1	1	MS21083C8	NUT
38	38	38	38	38	38	NAS1149C0332R	WASHER
				2	2	NAS1149C0363R	WASHER
1	1	1	1	1	1	NAS1149C0832R	WASHER
4	4	4	4	4	4	NAS1515H3L	WASHER

NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4/-5/-6 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.1 lbs
D2750-051/-052 = 25.7 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 19/64" SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

H	ADDED -051/-052 (ZN D5-1 SHEETS 4, 15-16); ADDED D2750-5/-6 (ZN C5-1 SHEETS 9, 10); D3488-3/-4 REPLACES D3488-041/-042 (ZN C5-1, D2-11/-12/-13/-14); D3793-5 REPLACES D3535-25 (ZN B8-1, C4-11/-12/-13/-14); NAS1149C0332R REPLACES AN960C10L (ZN A5-1, B1-11/-12/-13/-14, C7-11/-12/-13/-14); NAS1149C0832R REPLACES AN980C318L (ZN A5-1, C1-11/-12/-13/-14); REMOVED D3794-1/-3, AND D3536-25 GASKETS	ZF	18.03.05
G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS $+0.01/-0.000$, WAS $+0.100/-0.000$ (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 8413; QTY (5) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C818; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	08.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 1 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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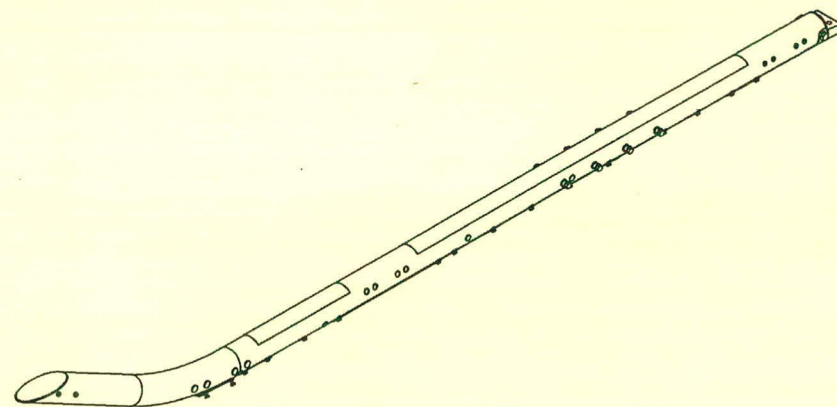
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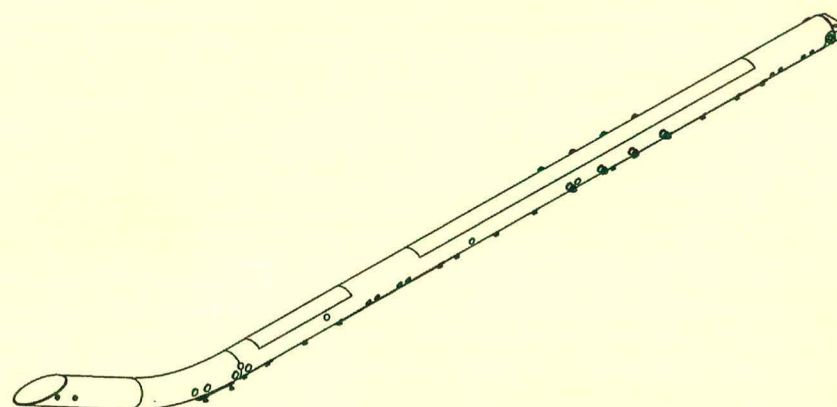
C

B

A



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

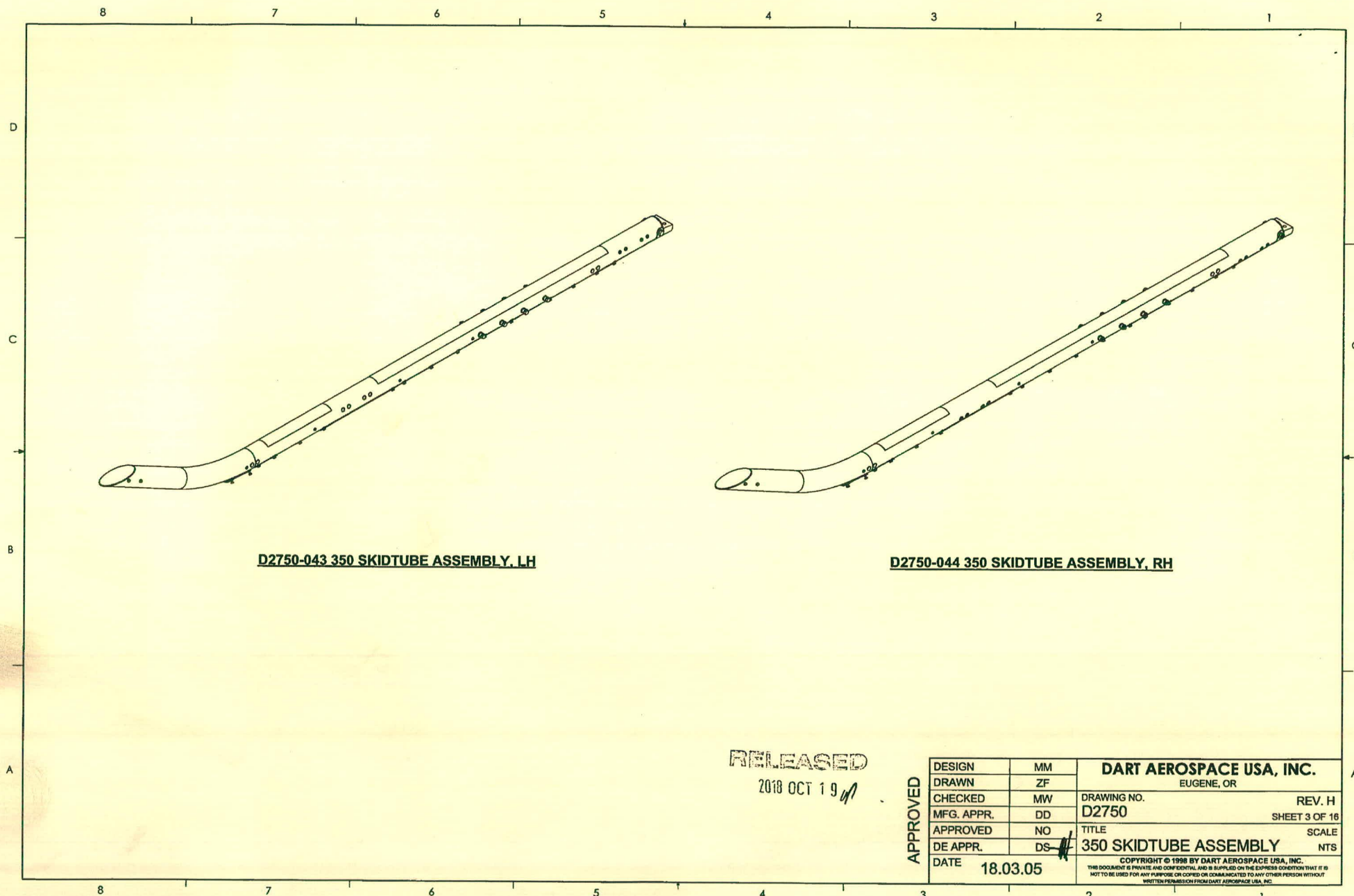
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2018 OCT 19
2018 10-19-18

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CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 2 OF 18
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DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



D2750-043 350 SKIDTUBE ASSEMBLY, LH

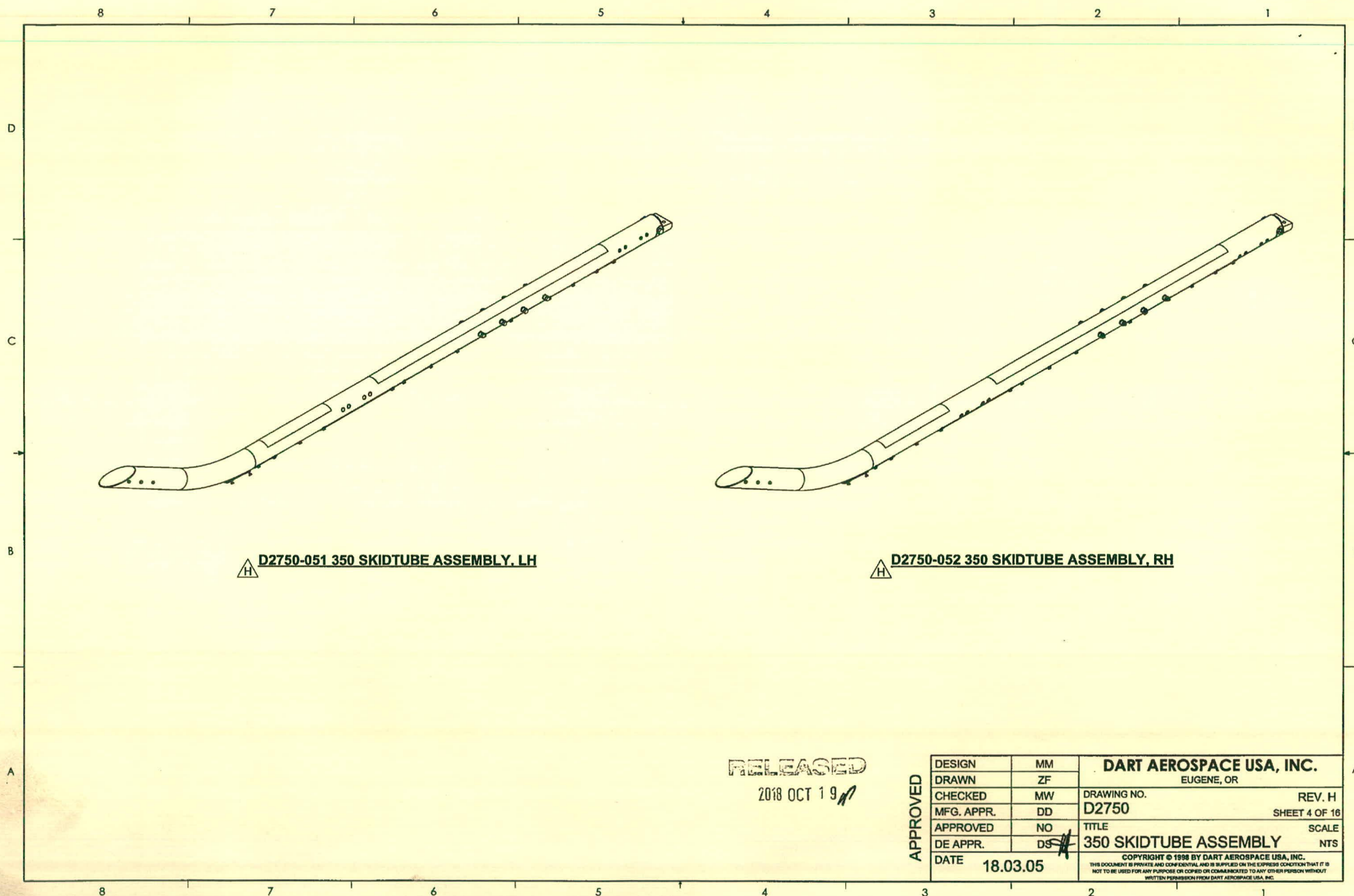
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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APPROVED	NO	TITLE	SCALE
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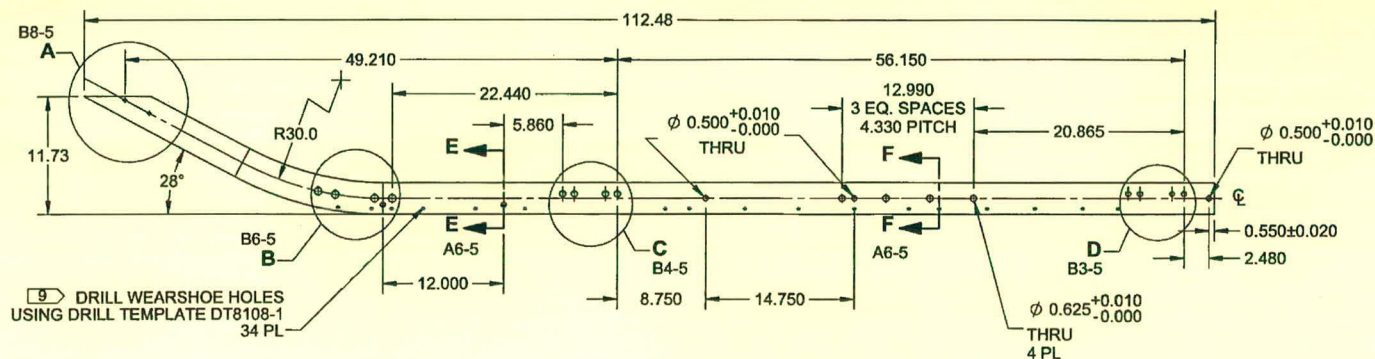
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D2750-052 350 SKIDTUBE ASSEMBLY, RH

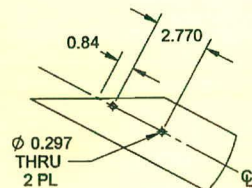
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2018 OCT 19

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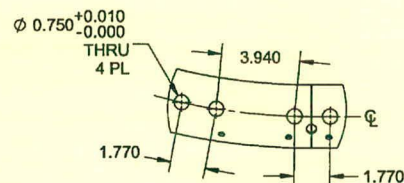
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APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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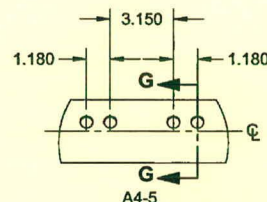
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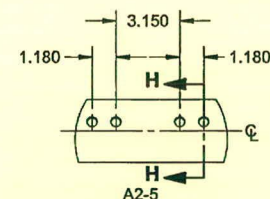
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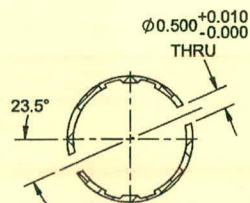
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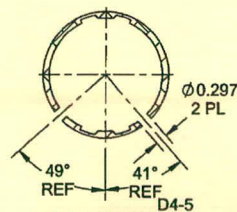
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SCALE 2X



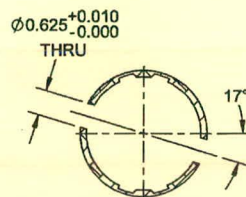
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SCALE 2X



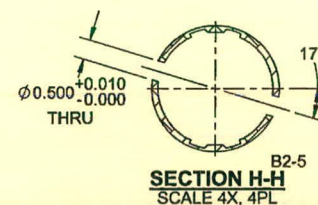
SECTION E-E
SCALE 4X, 2 PL



SECTION F-F
SCALE 4X, 17 PL



SECTION G-G
SCALE 4X, 4 PL

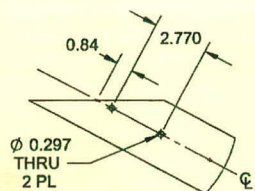
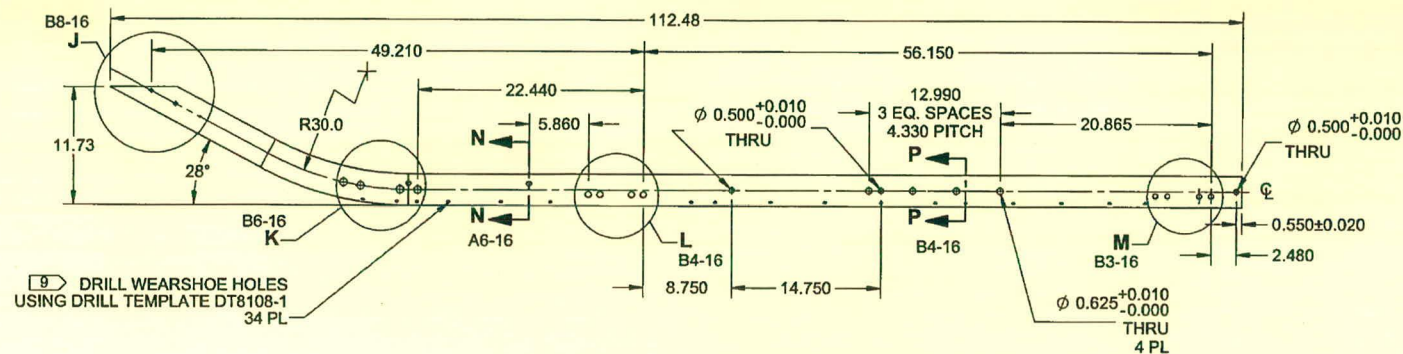


SECTION H-H
SCALE 4X, 4 PL

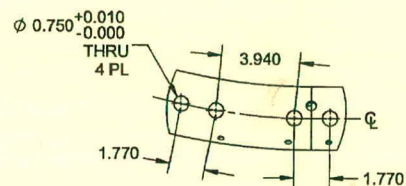
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2010 OCT 19

APPROVED

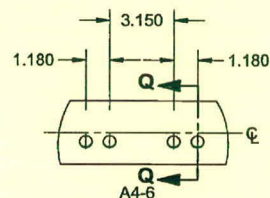
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 5 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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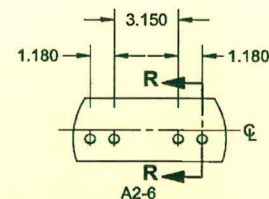
D7-6



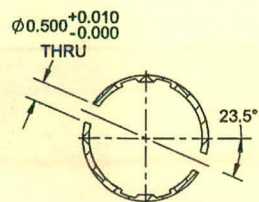
C7-6



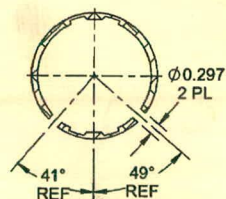
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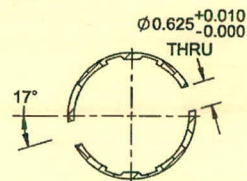
D3-6



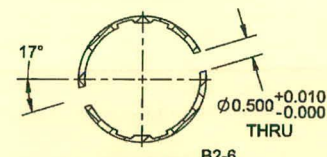
D6-6



D4-6



B4-6

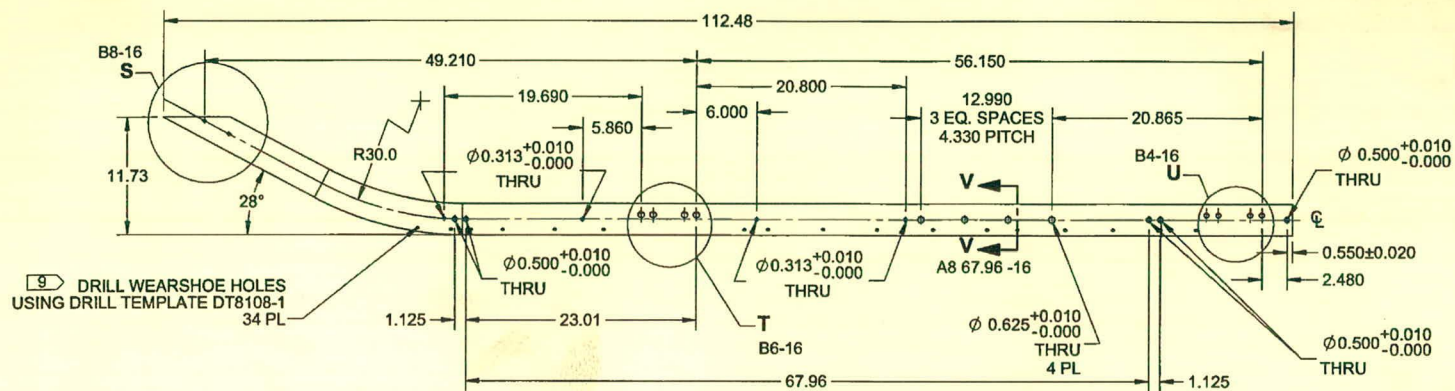


B2-6

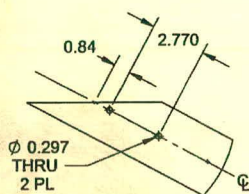
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2018 OCT 19

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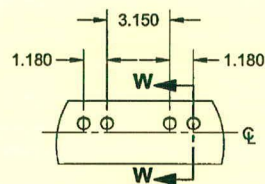
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DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 6 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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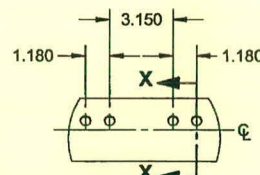
D2750-3 LH SKIDTUBE



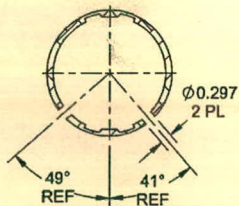
DETAIL S
SCALE 2X



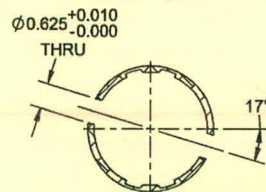
DETAIL T
SCALE 2X



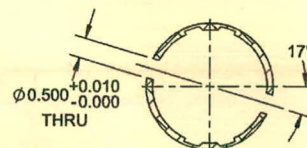
DETAIL U
SCALE 2X



SECTION V-V
SCALE 4X, 17 PL



SECTION W-W
SCALE 4X, 4 PL



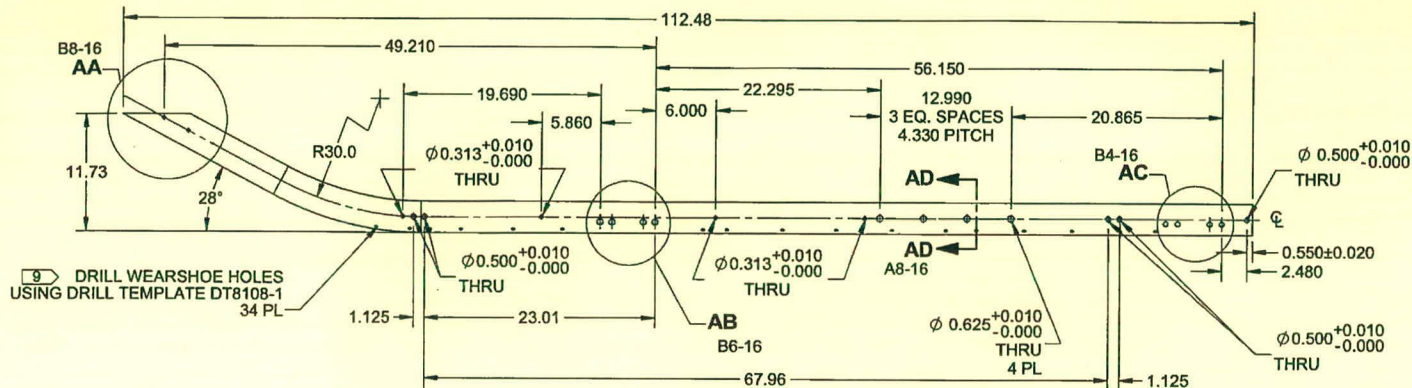
SECTION X-X
SCALE 4X, 4 PL

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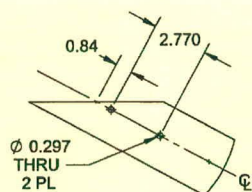
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APPROVED

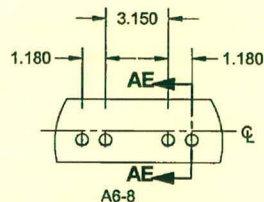
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DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 7 of 16
APPROVED	NO	TITLE	SCALE
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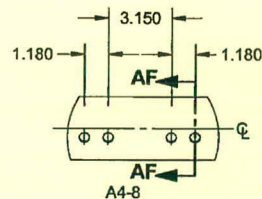
D2750-4 RH SKIDTUBE



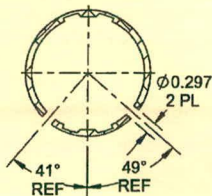
DETAIL AA
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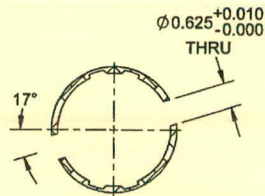
DETAIL AB
SCALE 2X



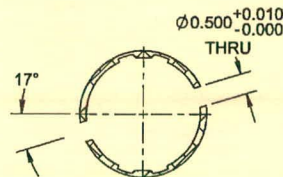
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SCALE 2X



SECTION AD-AD
SCALE 4X, 17 PL



SECTION AE-AE
SCALE 4X, 4 PL



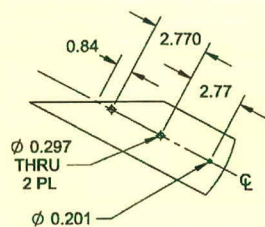
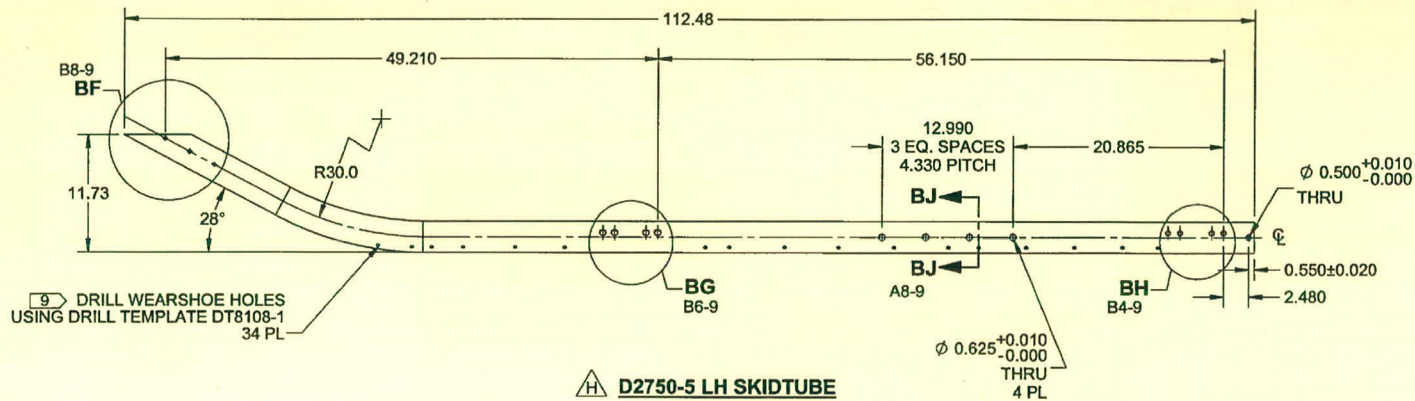
SECTION AF-AF
SCALE 4X, 4 PL

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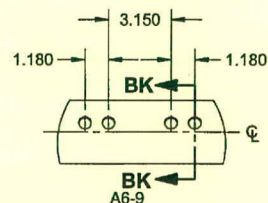
2018 OCT 19

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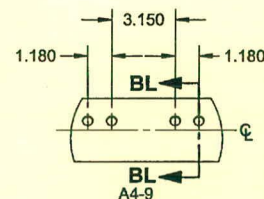
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DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 8 OF 1
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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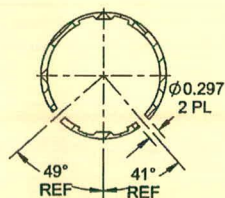
DETAIL BF
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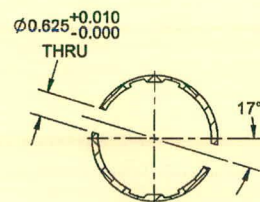
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SCALE 2X



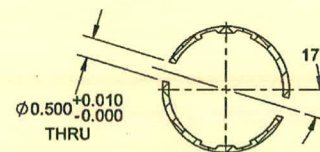
DETAIL BH
SCALE 2X



SECTION BJ-BJ
SCALE 4X, 17 PL



SECTION BK-BK
SCALE 4X, 4 PL

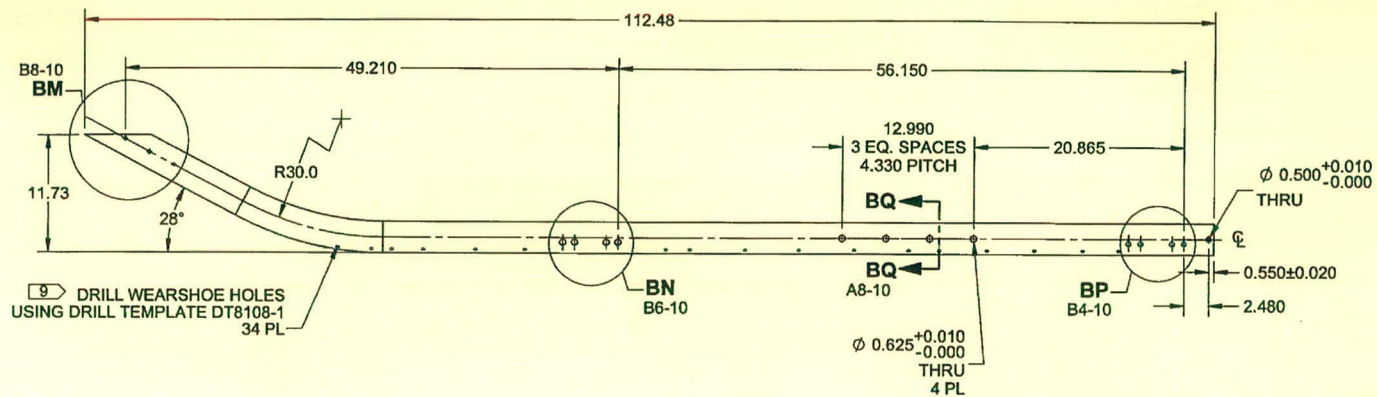


SECTION BL-BL
SCALE 4X, 4 PL

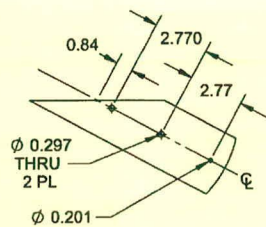
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2019 OCT 19

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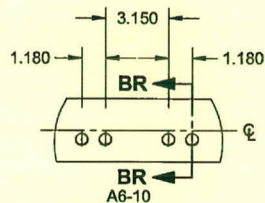
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DRAWN	ZF		
CHECKED	MW	DRAWING NO. D2750	REV. H
MFG. APPR.	DD	SHEET 9 OF 16	
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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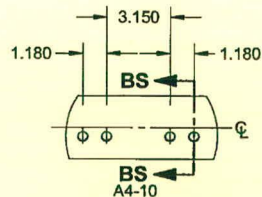
D2750-6 RH SKIDTUBE



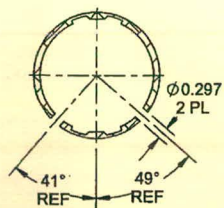
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SCALE 2X



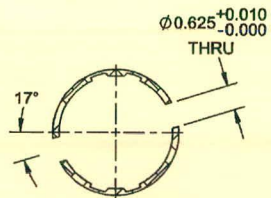
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SCALE 2X



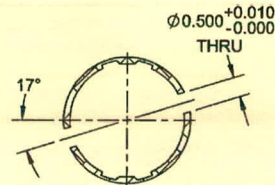
DETAIL BS
SCALE 2X



SECTION BQ-BQ
SCALE 4X, 17 PL



SECTION BR-BR
SCALE 4X, 4 PL

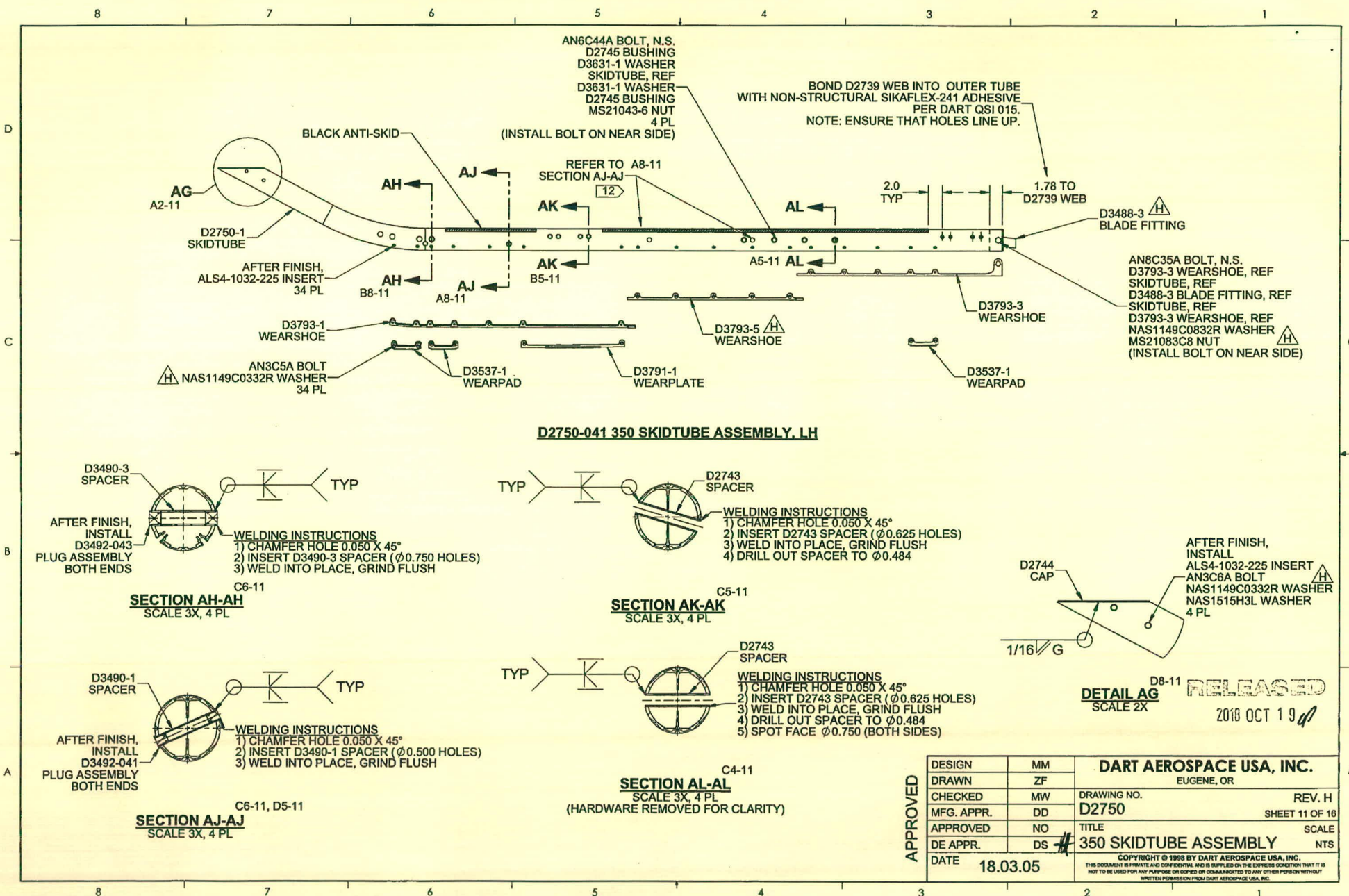


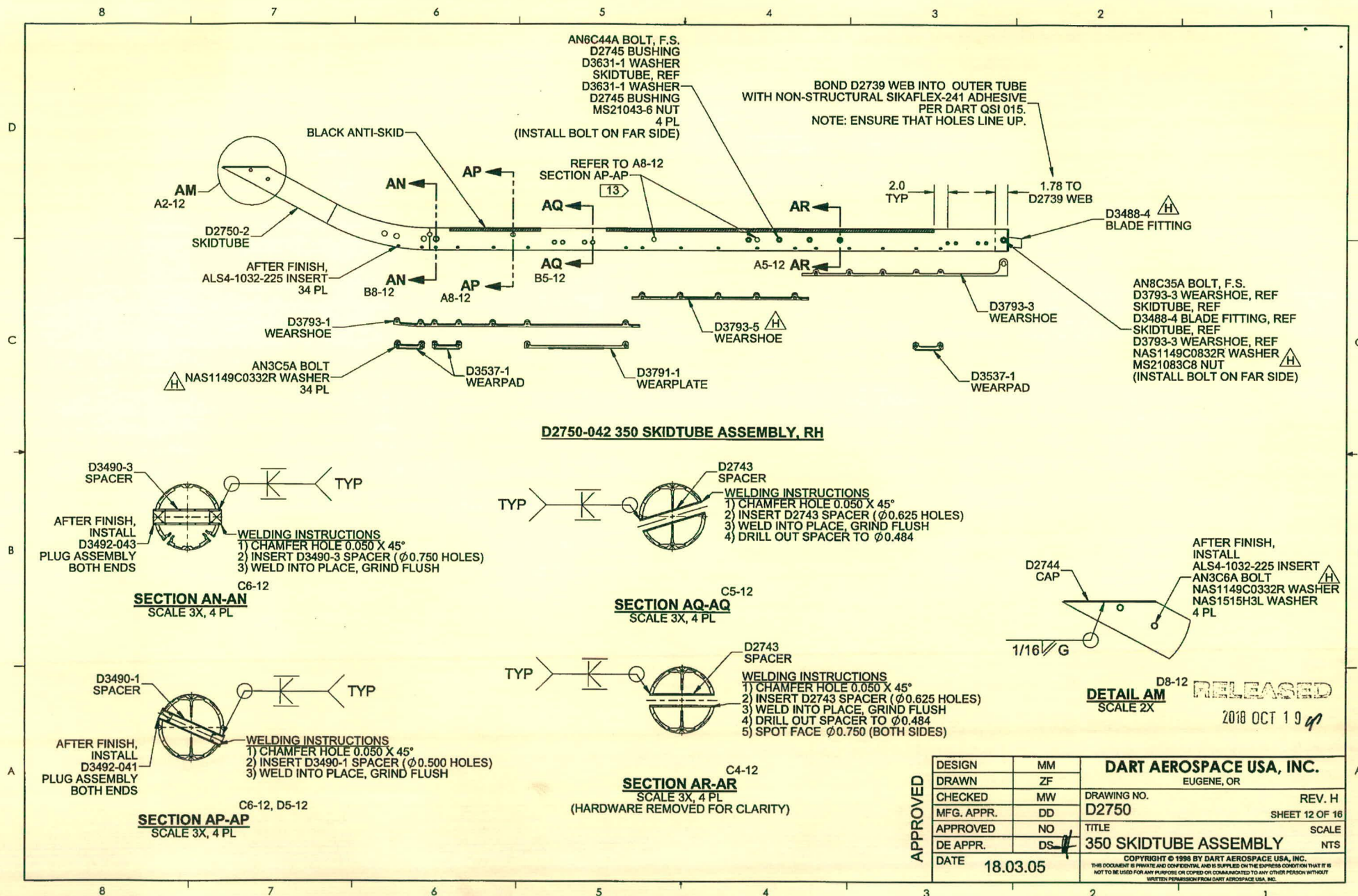
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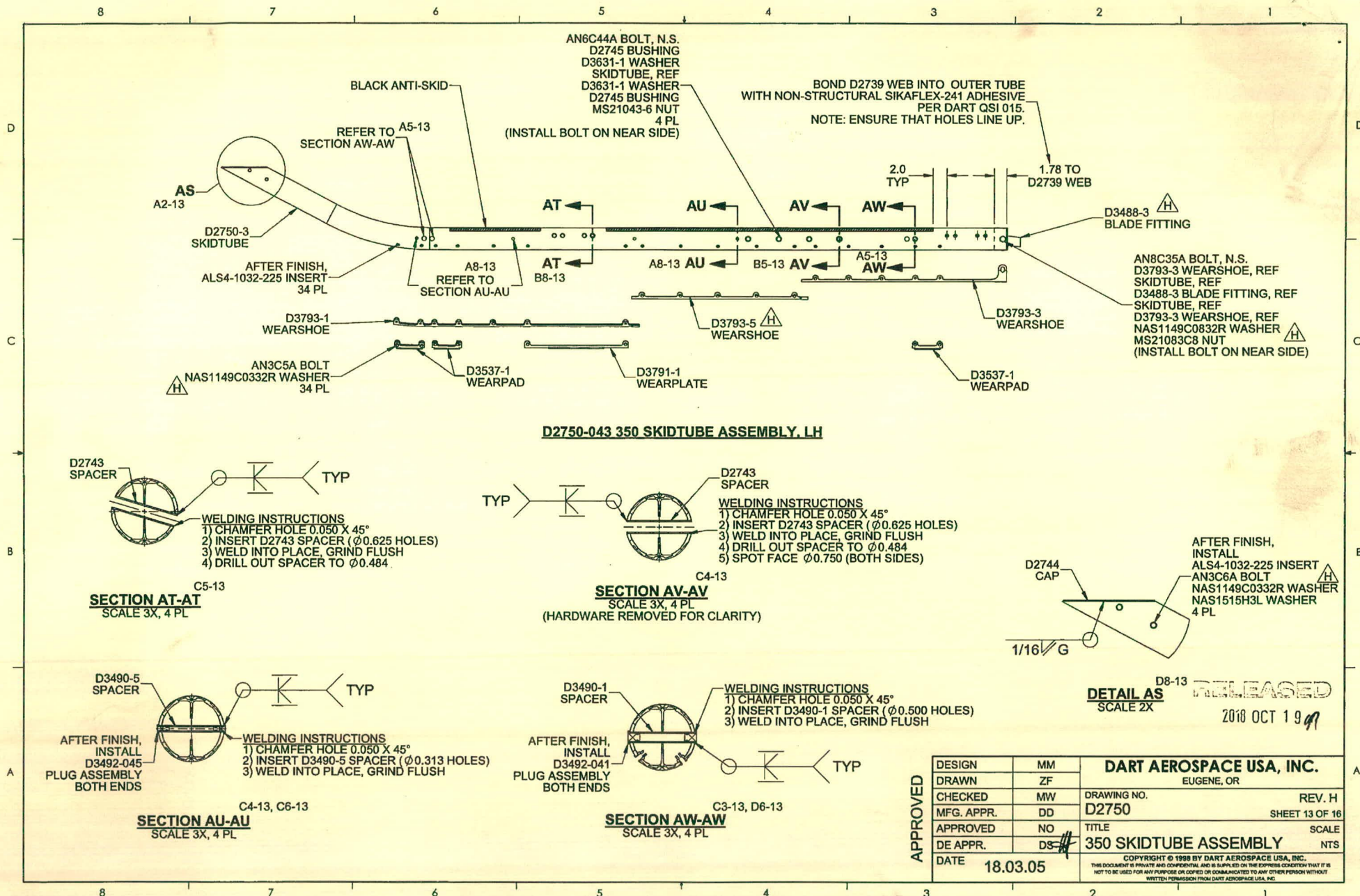
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2019 OCT 19

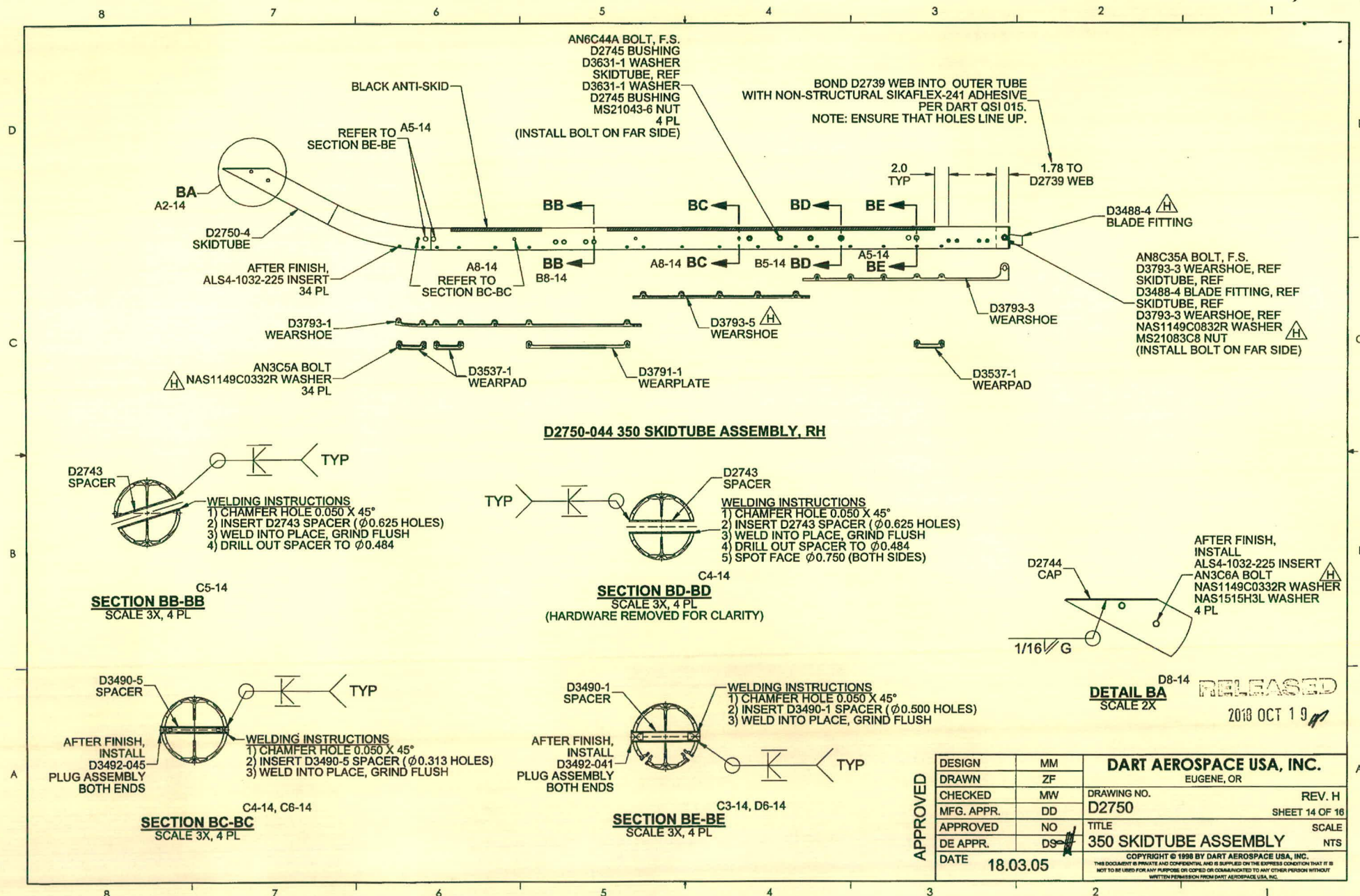
APPROVED

DESIGN	MM	DART AEROSPACE USA, INC.	
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CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 10 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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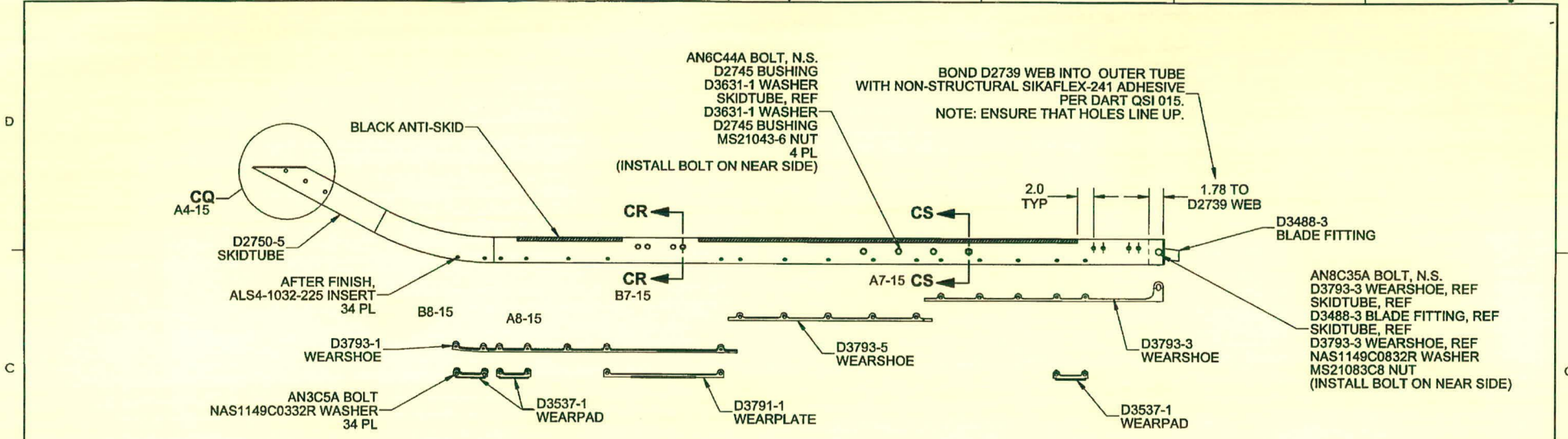




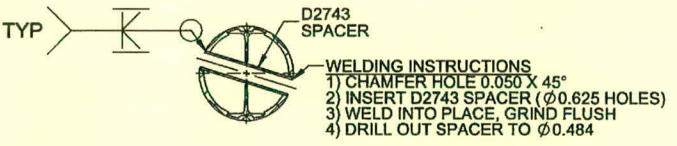




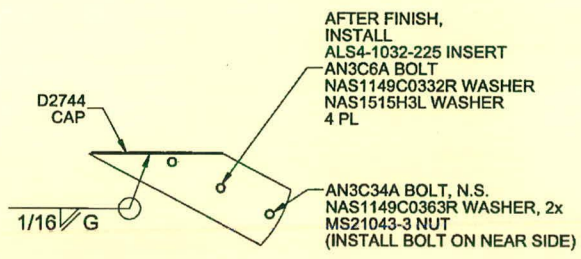
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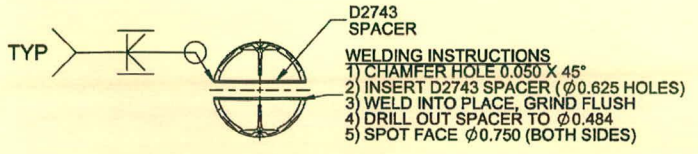
D2750-051 350 SKIDTUBE ASSEMBLY, LH



SECTION CR-CR
SCALE 3X, 4 PL



DETAIL CQ
SCALE 2X

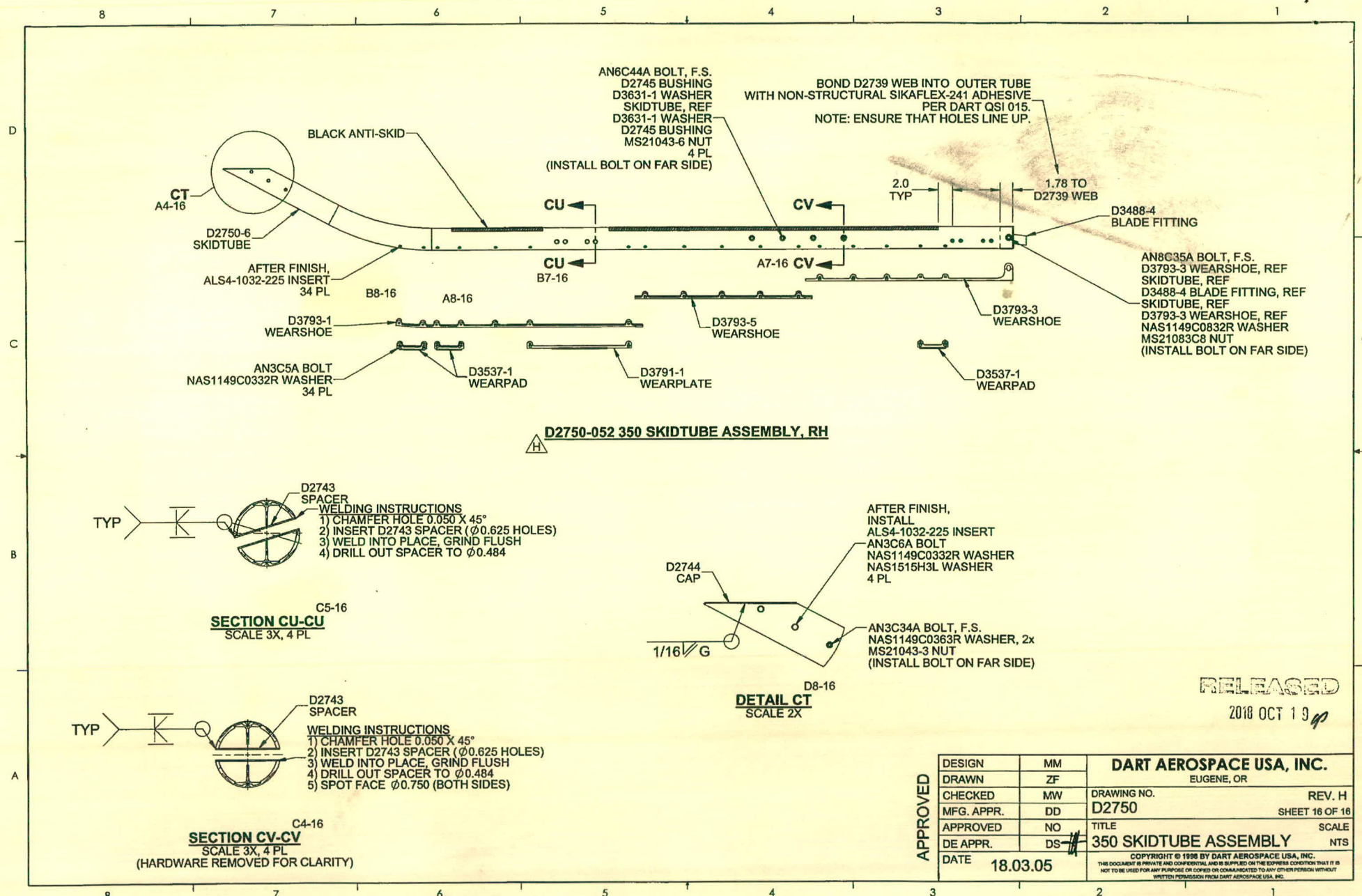


SECTION CS-CS
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

RELEASED
2018 OCT 19 42

APPROVED	DESIGN	MM	DART AEROSPACE USA, INC.	
	DRAWN	ZF	EUGENE, OR	
	CHECKED	MW	DRAWING NO.	REV. H
	MFG. APPR.	DD	D2750	SHEET 15 OF 18
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1





Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041713**

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO041713
PO Date: 11/13/18
Due Date: 11/16/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184225	D350-636-011	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____	Firmed	-	11/16/18	1 pcs	0 pcs	1 pcs	\$325.00/pcs	\$325.00
2	183650	D135-751-011	1- Apply Primer as per QSI 005 4.2.1.3.3 and dwg A/R Primer Batch: _____ 2- Paint two coats of White paint as per QSI 005 4.2 and dwg A/R Paint Batch: _____	Firmed	-	11/16/18	1 pcs	0 pcs	1 pcs	\$325.00/pcs	\$325.00
3	182678	D350-636-016	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____	Firmed	-	11/16/18	1 pcs	0 pcs	1 pcs	\$325.00/pcs	\$325.00
4	185412	D350-636-013	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____	Firmed	-	11/16/18	1 pcs	0 pcs	1 pcs	\$325.00/pcs	\$325.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041713**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	184892	D350-636-015	1- PRIME AS PER DWG AND QSI 005 4.2.1.3.3 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____	Firmed	-	11/16/18	1 pcs	0 pcs	1 pcs	\$325.00/pcs	\$325.00
Grand Total:											\$1,625.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/14/18 9:19 AM dart.tsimiklis.chrisoula

QTY -041	QTY -042	QTY -043	QTY -044	QTY -051	QTY -052	P/N	DESCRIPTION
X						D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X					D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X				D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X			D2750-044	350 SKIDTUBE ASSEMBLY, RH
				X		D2750-051	350 SKIDTUBE ASSEMBLY, LH
					X	D2750-052	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	1	1	D2739	WEB
8	8	8	8	8	8	D2743	CROSS BOLT SPACER
1	1	1	1	1	1	D2744	CAP
8	8	8	8	8	8	D2745	BUSHING
1						D2750-1	350 SKIDTUBE ASSEMBLY
	1					D2750-2	350 SKIDTUBE ASSEMBLY
		1				D2750-3	350 SKIDTUBE ASSEMBLY
			1			D2750-4	350 SKIDTUBE ASSEMBLY
				1		D2750-5	350 SKIDTUBE ASSEMBLY
					1	D2750-6	350 SKIDTUBE ASSEMBLY
1		1		1		D3488-3	BLADE FITTING, LH
	1		1		1	D3488-4	BLADE FITTING, RH
4	4	4	4			D3490-1	CROSS BOLT SPACER
4	4					D3490-3	CROSS BOLT SPACER
		4	4			D3490-5	CROSS BOLT SPACER
8	8	8	8			D3492-041	PLUG
8	8					D3492-043	PLUG
		8	8			D3492-045	PLUG
3	3	3	3	3	3	D3537-1	WEARPAD
8	8	8	8	8	8	D3631-1	WASHER
1	1	1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	1	1	D3793-5	WEARSHOE
38	38	38	38	38	38	ALS4-1032-225	INSERT
				1	1	AN3C34A	BOLT
34	34	34	34	34	34	AN3C5A	BOLT
4	4	4	4	4	4	AN3C6A	BOLT
4	4	4	4	4	4	AN6C44A	BOLT
1	1	1	1	1	1	AN8C35A	BOLT
				1	1	MS21043-3	NUT
4	4	4	4	4	4	MS21043-6	NUT
1	1	1	1	1	1	MS21083C8	NUT
38	38	38	38	38	38	NAS1149C0332R	WASHER
				2	2	NAS1149C0363R	WASHER
1	1	1	1	1	1	NAS1149C0832R	WASHER
4	4	4	4	4	4	NAS1515H3L	WASHER

NOTES:

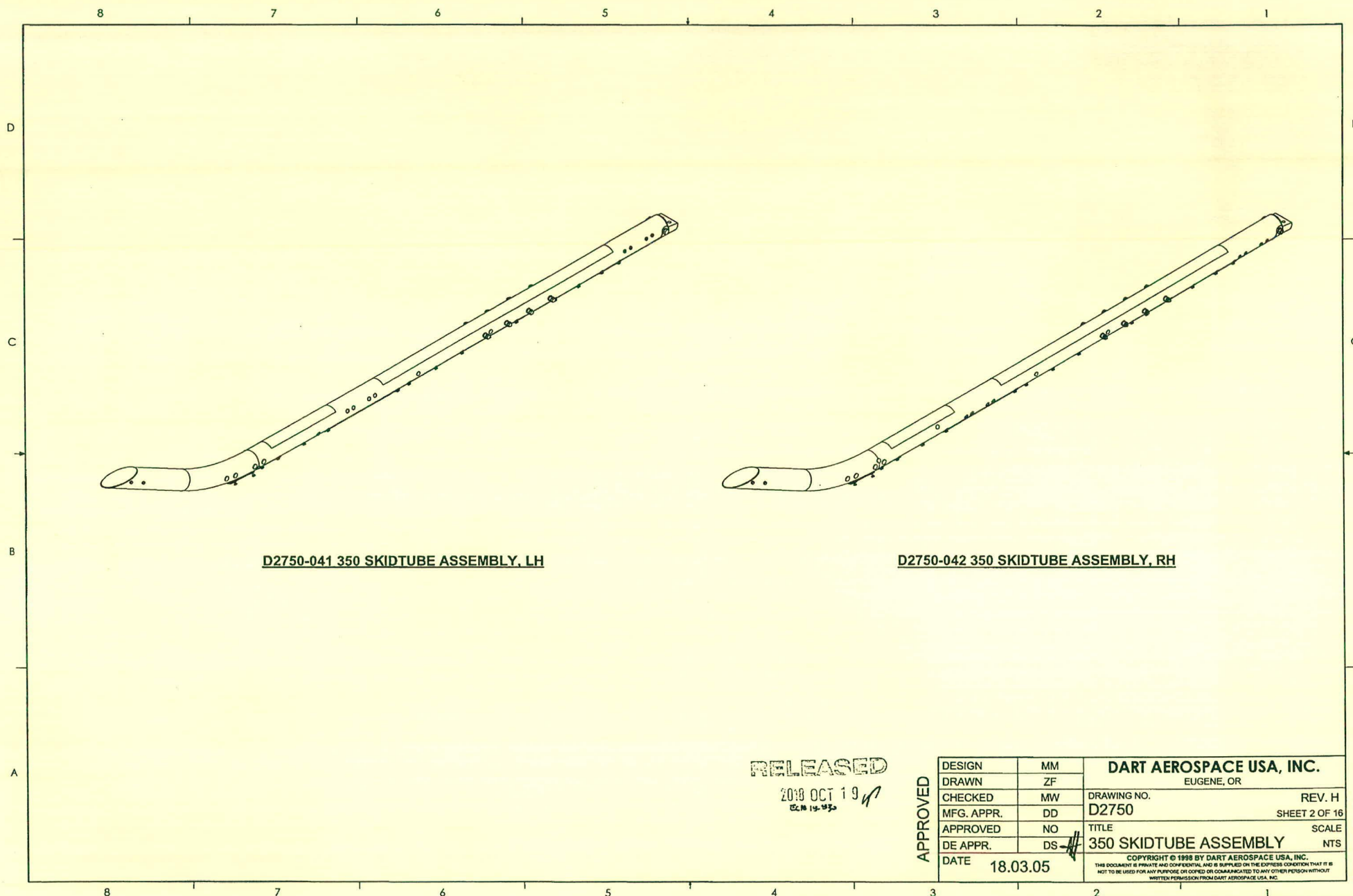
- 1) MATERIAL: MAKE D2750-1/-2/-3/-4/-5/-6 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB. STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2 OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.1 lbs
D2750-051/-052 = 25.7 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 19/64" SIZE HOLES (ϕ 0.297) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

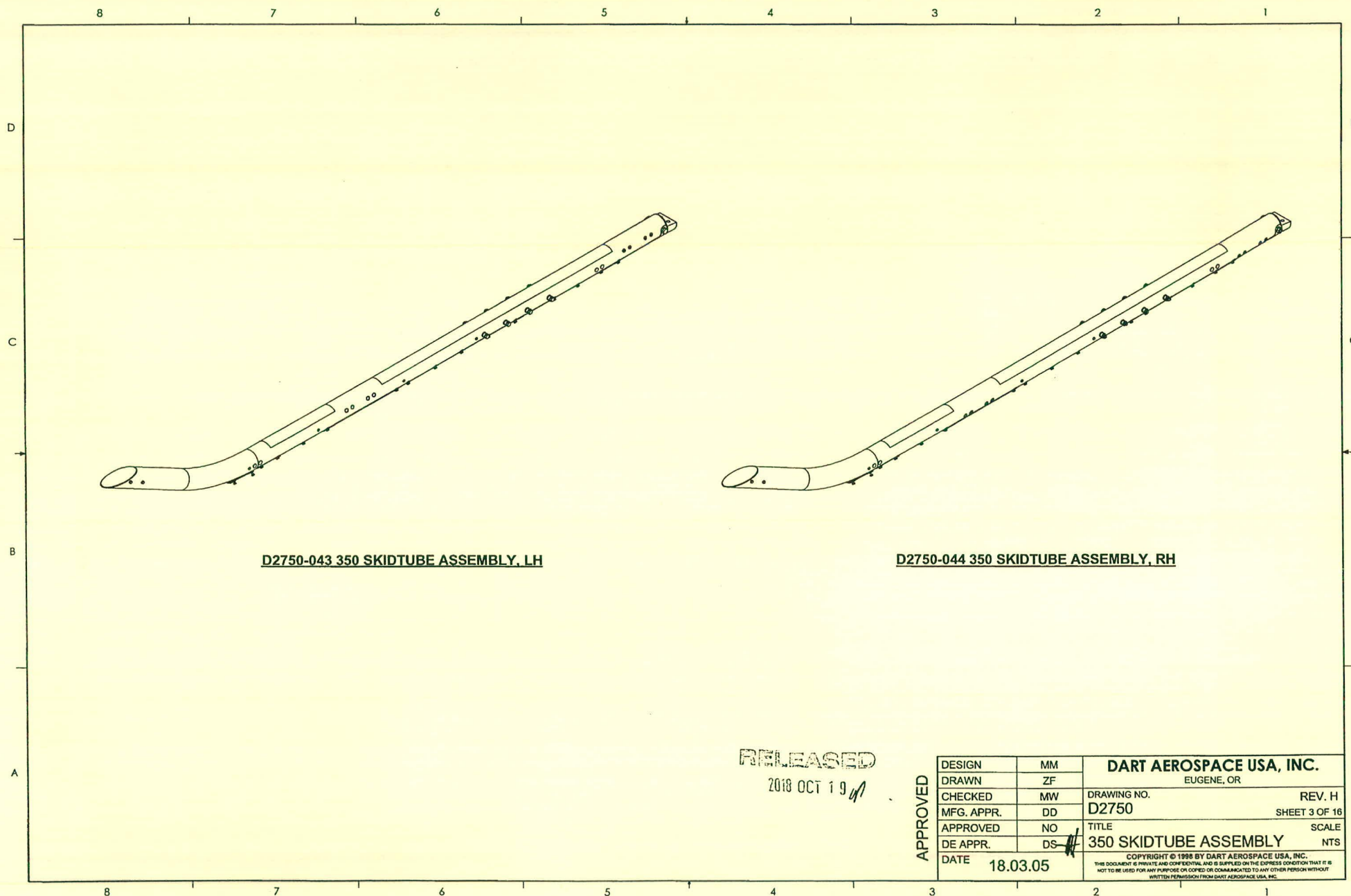
H	ADDED -051/-052 (ZN D5-1 SHEETS 4, 15-16); ADDED D2750-5/-6 (ZN C5-1 SHEETS 9, 10); D3488-3/-4 REPLACES D3488-041/-042 (ZN C5-1, D2-11/-12/-13/-14); D3793-5 REPLACES D3535-25 (ZN B6-1, C4-11/-12/-13/-14); NAS1149C0332R REPLACES AN960C10L (ZN A5-1, B1-11/-12/-13/-14, C7-11/-12/-13/-14); NAS1149C0832R REPLACES AN960C816L (ZN A5-1, C1-11/-12/-13/-14); REMOVED D3794-1/-3, AND D3536-25 GASKETS	ZF	18.03.05
G	CORRECTED TOLERANCE ON ϕ 0.500 THRU HOLE: IS +0.01/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (6 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DED 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV	DESCRIPTION	BY	DATE
DESIGN	MM	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 1 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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3:18:53

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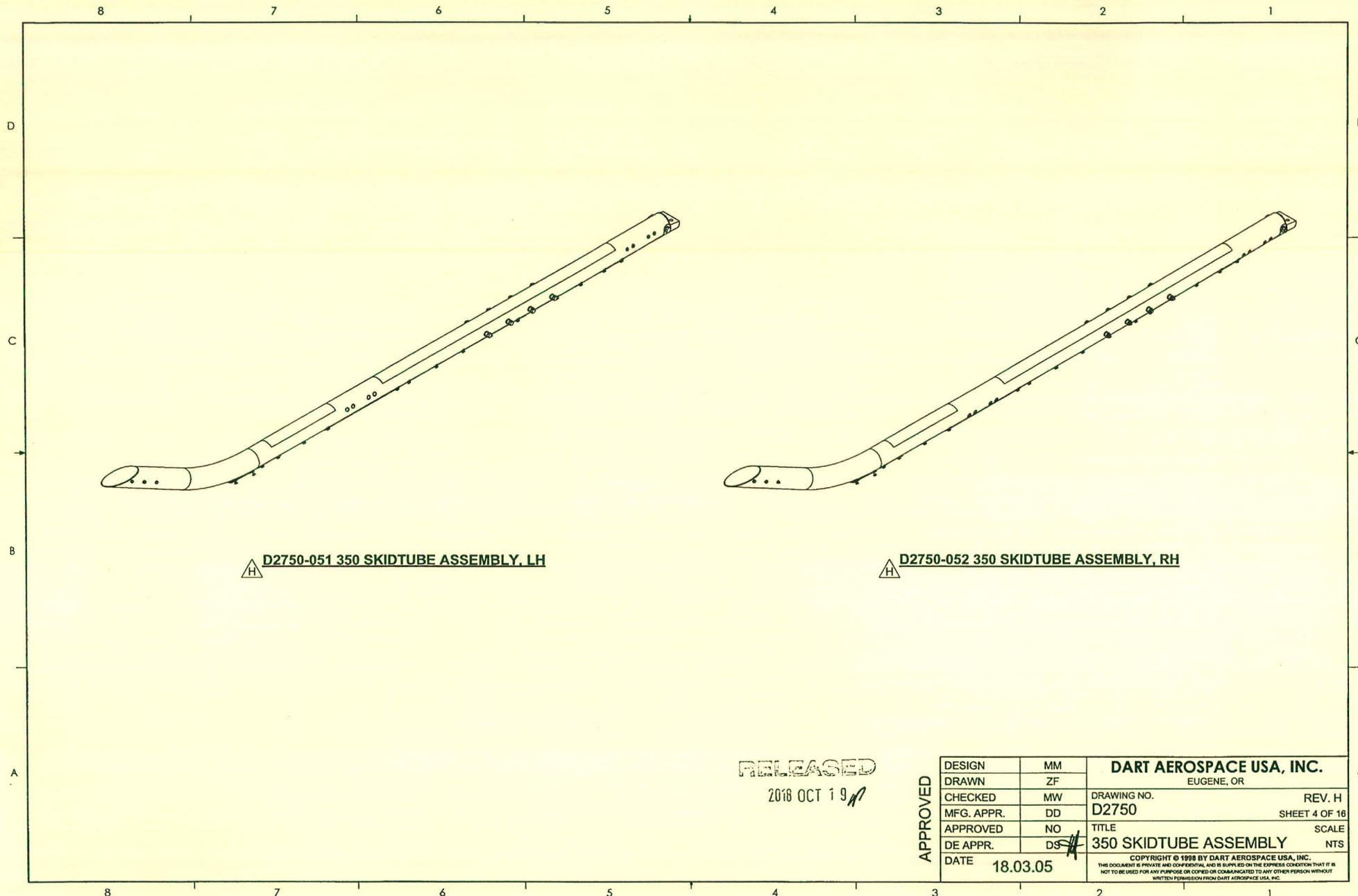




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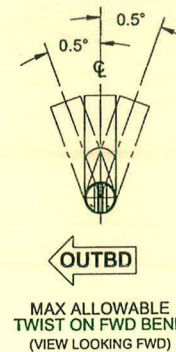
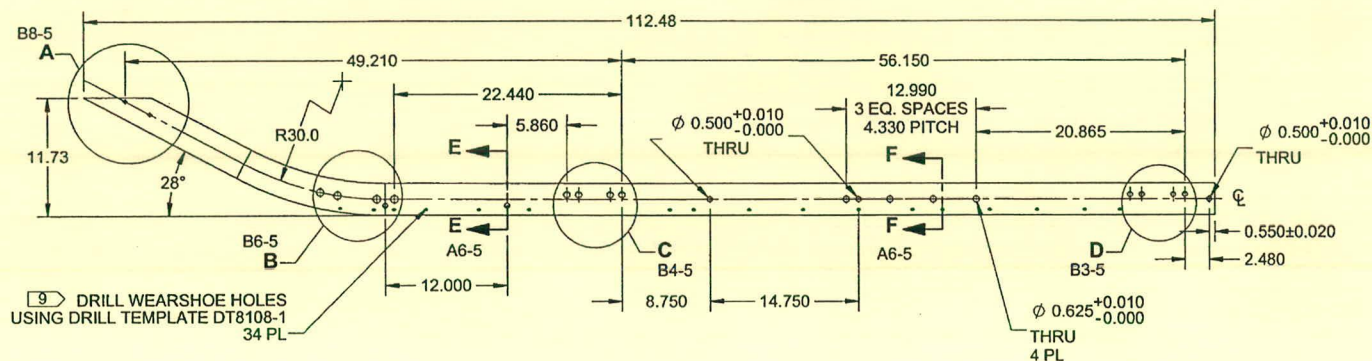
D2750-051 350 SKIDTUBE ASSEMBLY, LH

D2750-052 350 SKIDTUBE ASSEMBLY, RH

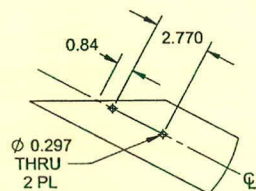
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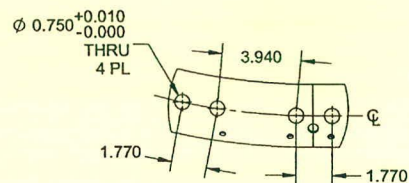
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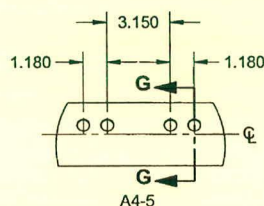
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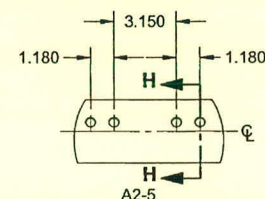
D7-5
DETAIL A
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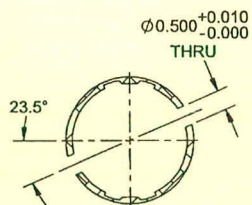
C7-5
DETAIL B
SCALE 2X



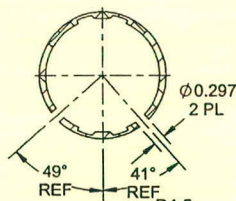
D5-5
DETAIL C
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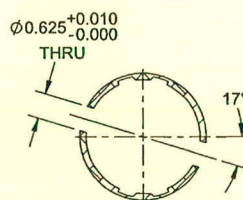
D3-5
DETAIL D
SCALE 2X



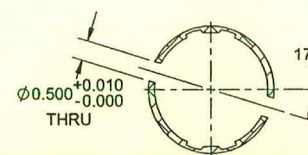
D5-5
SECTION E-E
SCALE 4X, 2 PL



D4-5
SECTION F-F
SCALE 4X, 17 PL



B4-5
SECTION G-G
SCALE 4X, 4 PL

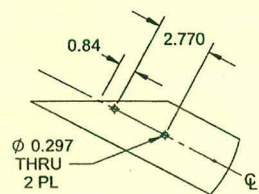
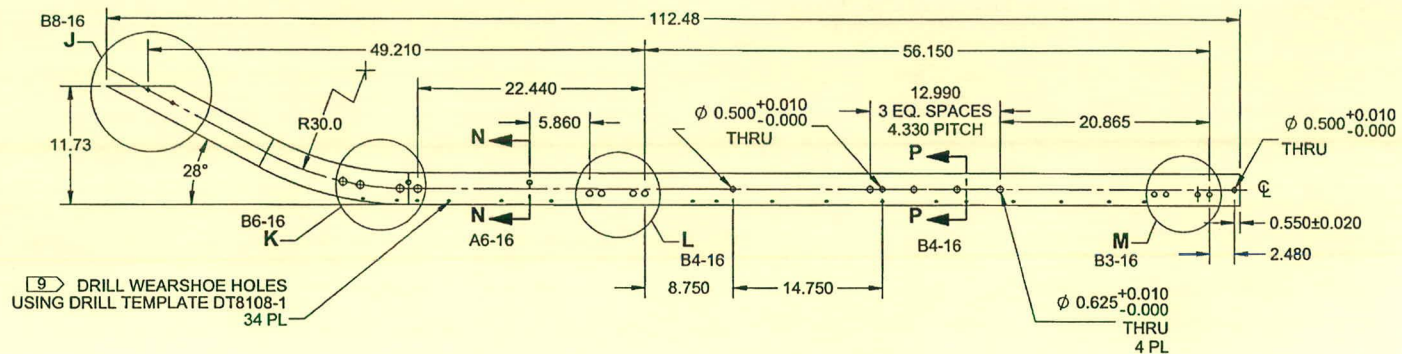


B2-5
SECTION H-H
SCALE 4X, 4 PL

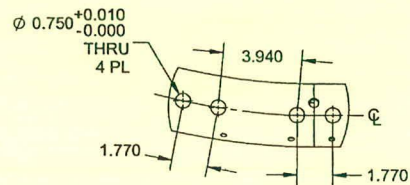
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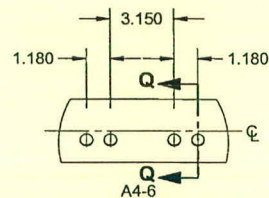
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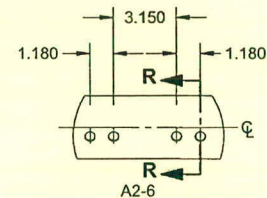
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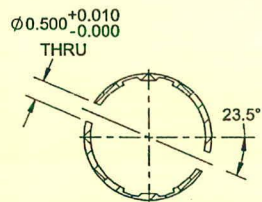
C7-6



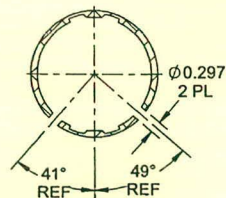
D5-6



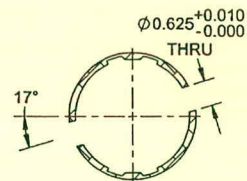
D3-6



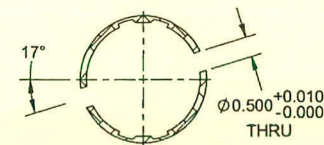
D6-6



D4-6



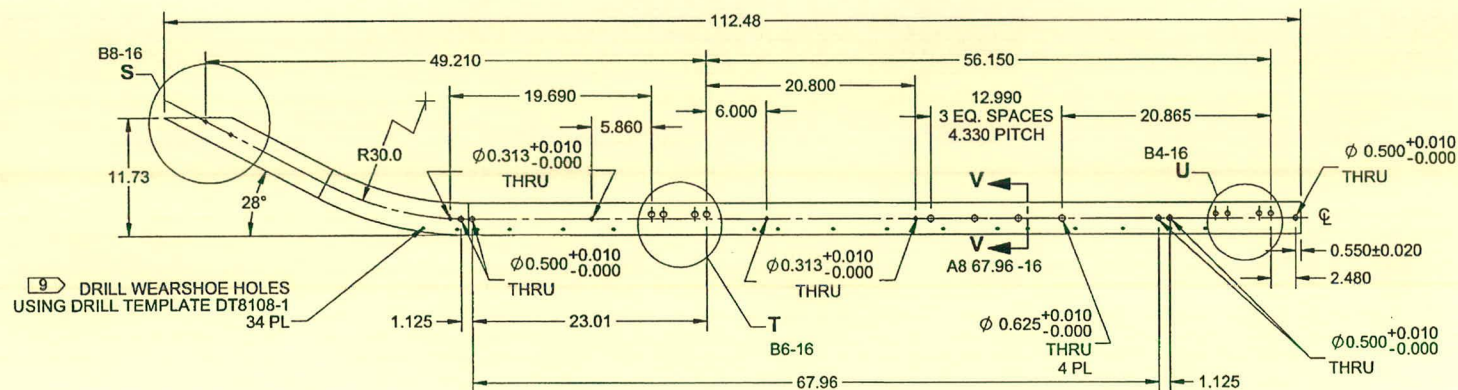
B4-6



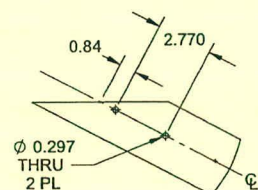
B2-6

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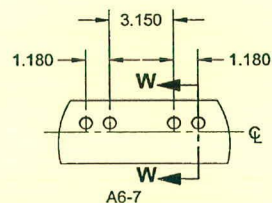


D2750-3 LH SKIDTUBE



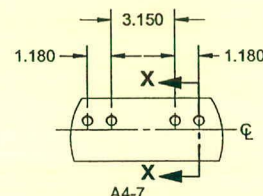
D7-7

DETAIL S
SCALE 2X



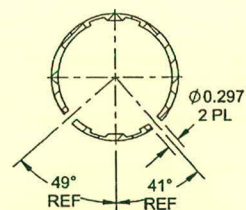
C5-7

DETAIL T
SCALE 2X



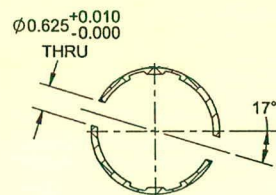
D3-7

DETAIL U
SCALE 2X



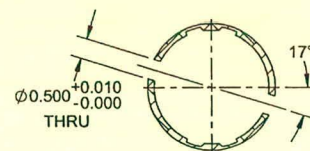
D4-7

SECTION V-V
SCALE 4X, 17 PL



B6-7

SECTION W-W
SCALE 4X, 4 PL



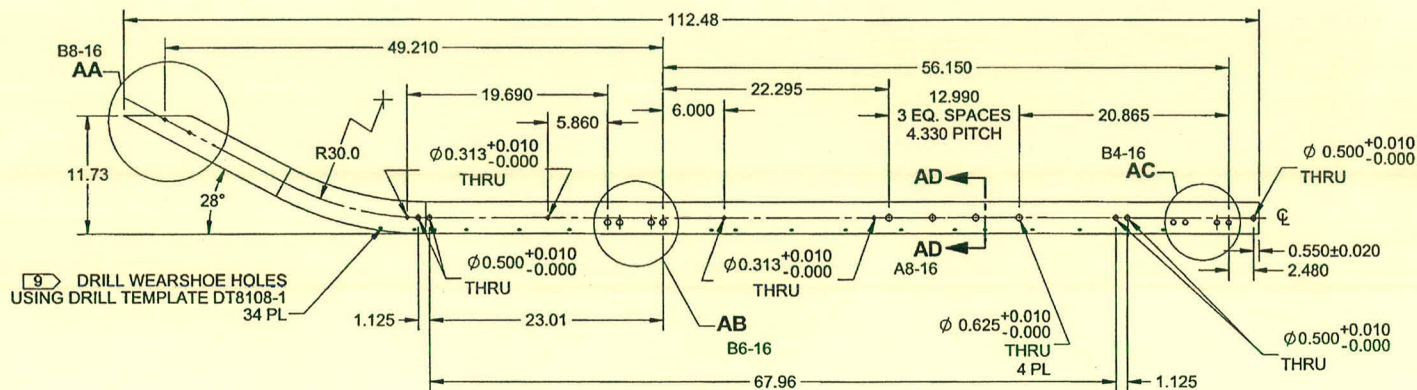
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SECTION X-X
SCALE 4X, 4 PL

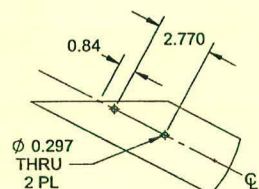
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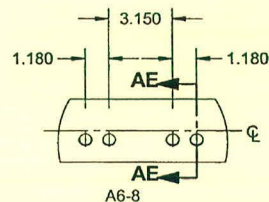
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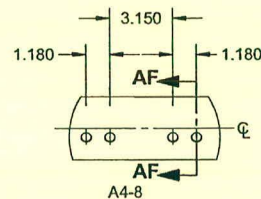
D2750-4 RH SKIDTUBE



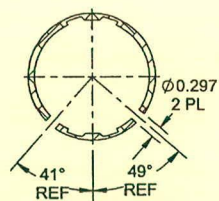
DETAIL AA
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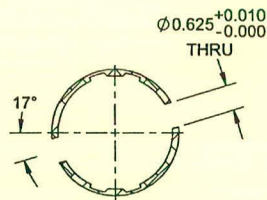
DETAIL AB
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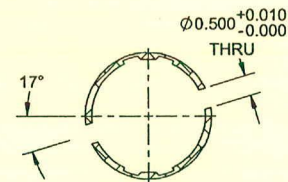
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 4X, 17 PL



SECTION AE-AE
SCALE 4X, 4 PL

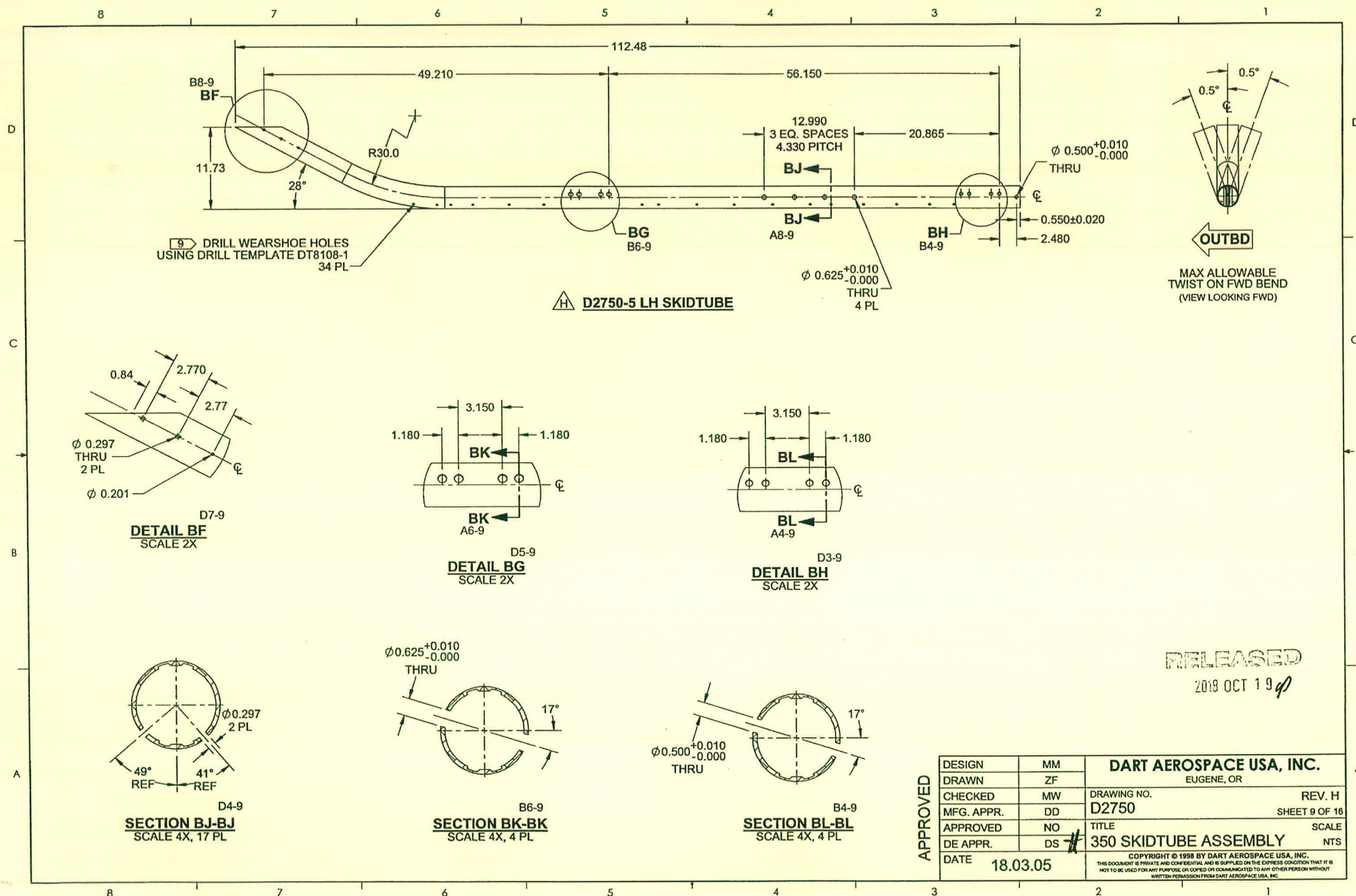


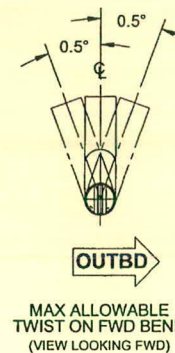
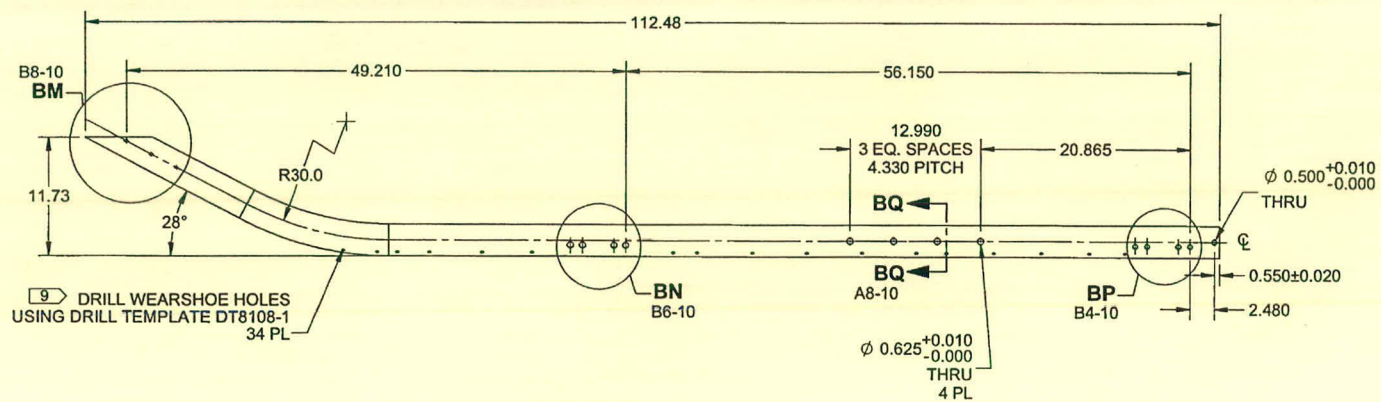
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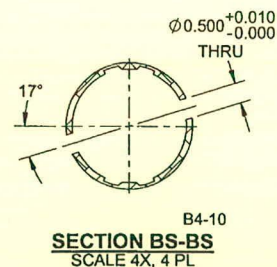
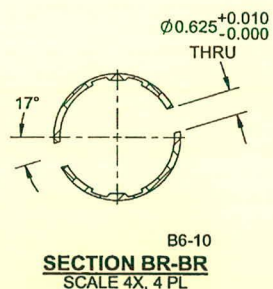
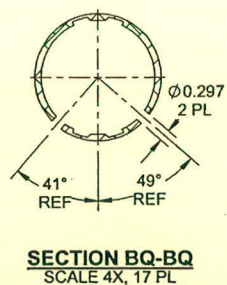
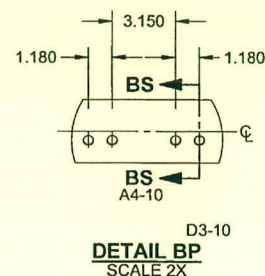
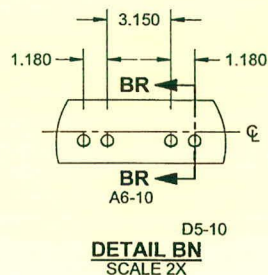
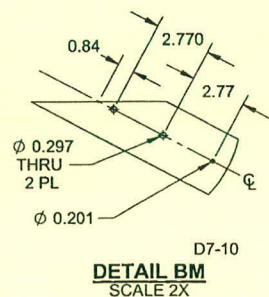
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DRAWN	ZF		
CHECKED	MW		
MFG. APPR.	DD		
APPROVED	NO		
DE APPR.	DS		
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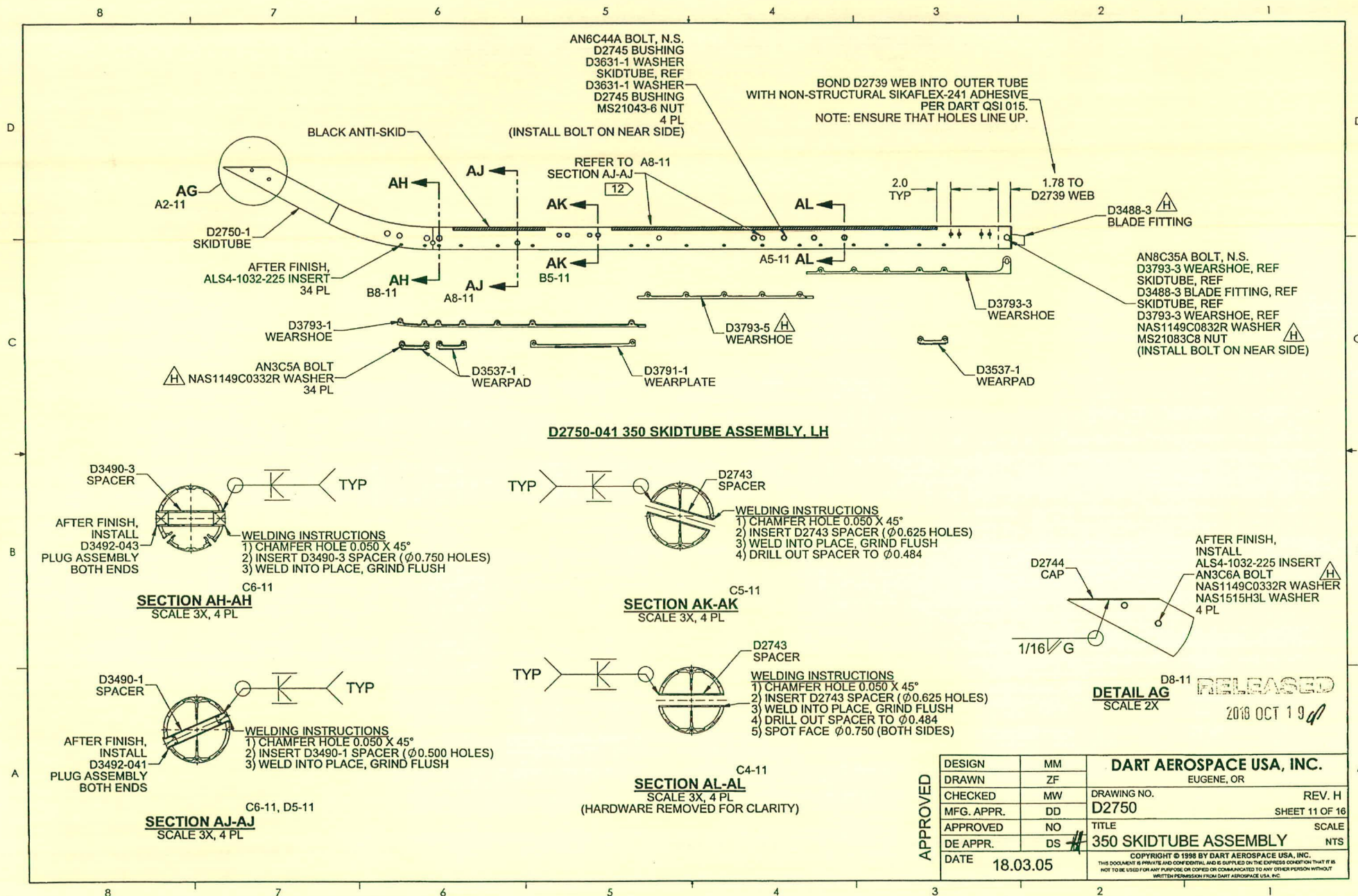


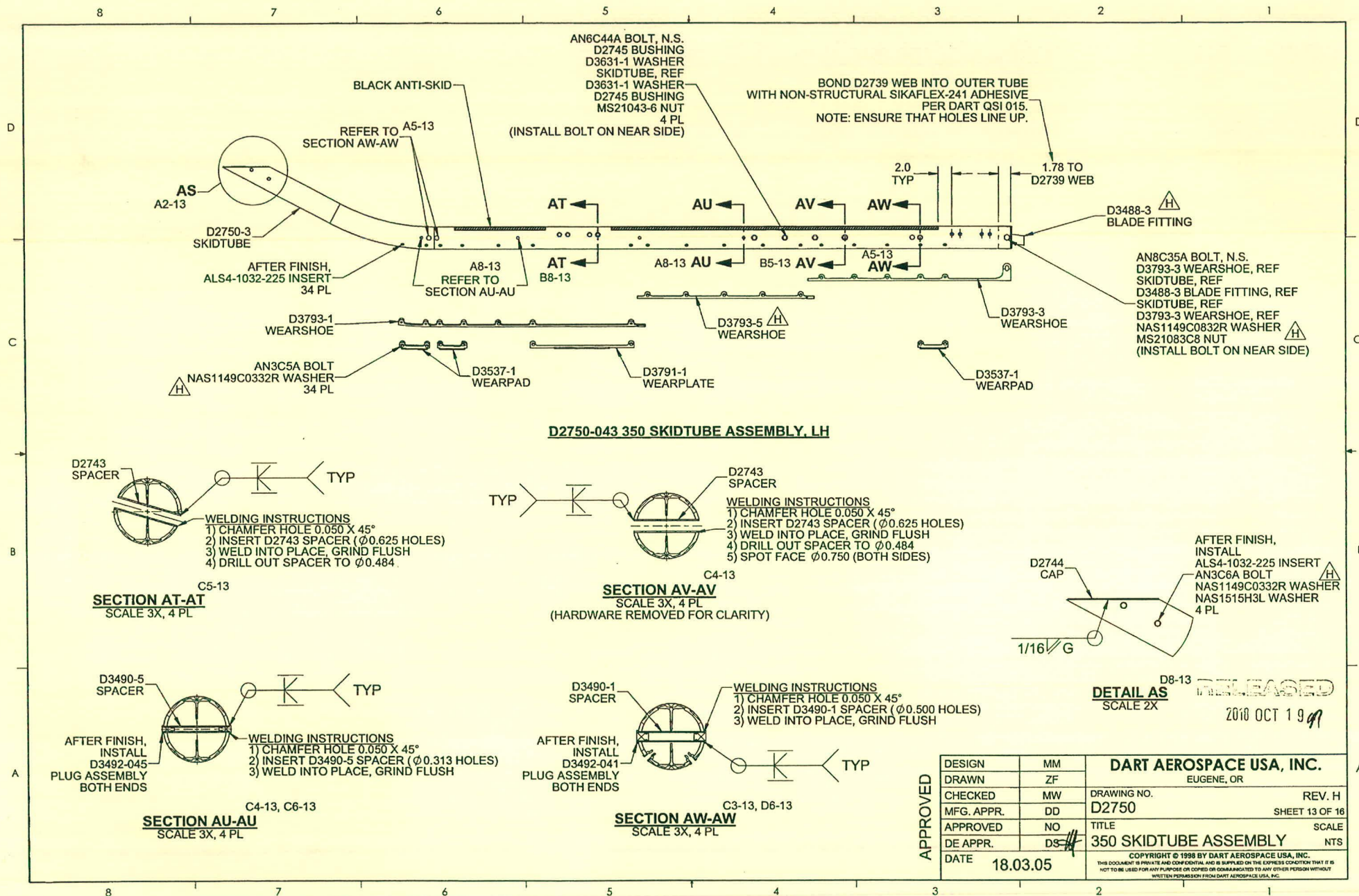
D2750-6 RH SKIDTUBE



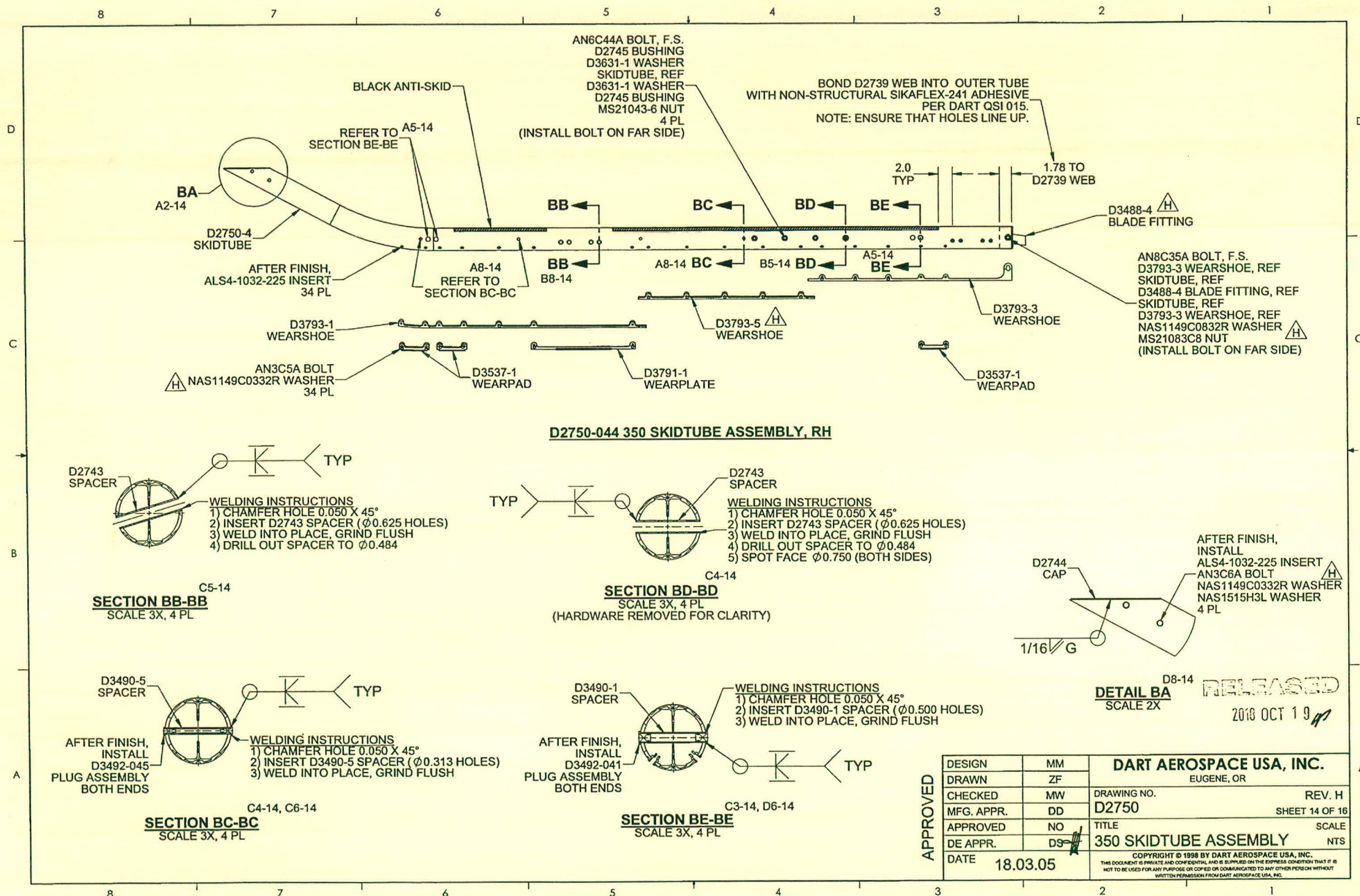
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2018 OCT 19

32.10.3 D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 008 OR LATER AND
D350-636-021/-022 SKIDTUBES AT CHG 001 OR LATER

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -021	Qty -022	Qty -049	Part Number	Description
	X							D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
		X						D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
			X					D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE
				X				D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE
					X			D350-636-021	SKIDTUBE INSTALLATION, LH, STD
						X		D350-636-022	SKIDTUBE INSTALLATION, RH, STD
							X	D350-636-049	WEARSHOE KIT
1	1							D2750-041	SKIDTUBE ASSEMBLY, LH
1		1						D2750-042	SKIDTUBE ASSEMBLY, RH
1			1					D2750-043	SKIDTUBE ASSEMBLY, LH
1				1				D2750-044	SKIDTUBE ASSEMBLY, RH
1					1			D2750-051	SKIDTUBE ASSEMBLY, LH
1						1		D2750-052	SKIDTUBE ASSEMBLY, RH
*1	1							D2750-1	SKIDTUBE WELDMENT, LH
*1		1						D2750-2	SKIDTUBE WELDMENT, RH
*1			1					D2750-3	SKIDTUBE WELDMENT, LH
*1				1				D2750-4	SKIDTUBE WELDMENT, RH
1					1			D2750-5	SKIDTUBE WELDMENT, LH
1						1		D2750-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8	8	8		22541N120	NUT
*5	1	1	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1	1	1		NAS1149C0832R	WASHER
*7	1	1	1	1	1	1		MS21083C8	NUT
8	1		1		1			D3488-3	BLADE FITTING, LH
8		1		1		1		D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1		D2741	BLADE
10	2	2	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2	2	2		NAS1149DO863J	WASHER
11C							8	D3672-1	WASHER
12	2	2	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4	4	4		NAS1149C0332R	WASHER
*20B	4	4	4	4	4	4		NAS1515H3L	WASHER
*22	3	3	3	3	3	3	3	D3537-1	WEARPAD
*22A	1	1	1	1	1	1	1	D3791-1	WEARPLATE

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Revision: 4

32-00-00

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Change Record

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Part Number: D350-636-013/-014

Description: SKIDTUBE LH/RH, FLOAT COMPATIBLE

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